READ THIS FIRST

Model G0555LX/G0555LANV

******IMPORTANT UPDATE******

For Machines Mfd. Since 01/14 and Owner's Manual Revised 04/13

For questions or help with this product contact Tech Support at (570) 546-9663 or techsupport@grizzly.com

The following change was recently made to this machine since the owner's manual was printed:

- An additional set of ¼" eccentrics has been included with this bandsaw.

Aside from this information, all other content in the owner's manual applies and MUST be read and understood for your own safety. **IMPORTANT: Keep this update with the owner's manual for future reference.**

For questions or help, contact our Tech Support at (570) 546-9663 or techsupport@grizzly.com.

Introduction

The model G0555LX and G0555LANV bandsaws come with ⅜" eccentrics (Part # P0555LX129) installed behind the guide bearings. An additional set of ¼" eccentrics (Part # P0555LX136) has been included for easier guide bearing adjustments with ⅛" bandsaw blades.

The reduced thickness of the ¼" eccentrics provides more space for guide bearing adjustments with ⅛" blades, helping ensure blade support bearings will not damage the blade tooth set.

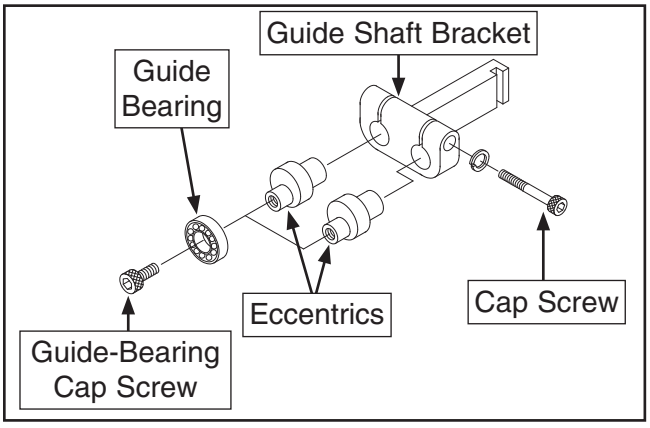

Figure 1. Blade support assembly.

Installation

1. DISCONNECT MACHINE FROM POWER!

2. Put on heavy leather gloves and open wheel covers. Remove blade as described in owner's manual.

3. Remove guide-bearing cap screws and guide bearings (see **Figure 1**).

4. Loosen cap screw on guide shaft bracket ½ turn.

5. Remove ⅜" eccentrics from guide shaft bracket, and replace with ¼" eccentrics.

6. Retighten cap screw on guide shaft bracket, then re-install guide bearings and guide-bearing cap screws.

7. Install ⅛" blade as described in owner's manual and close wheel covers.

8. Adjust upper and lower guide bearings and support bearings as described in manual.

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MODEL G0555LANV
14" DELUXE BANDSAW
ANNIVERSARY EDITION
MANUAL INSERT

The Model G0555LANV is the same machine as the Model G0555LX except for the striking black color and the 30-Year Anniversary design. Except for the differences noted in this insert, all other content in the Model G0555LX owner's manual applies to this machine. Before operating your new machine, you MUST read and understand this insert and the entire Model G0555LX manual to reduce the risk of injury when using this machine.

If you have any further questions about this manual insert or your machine, contact our Technical Support at (570) 546-9663 or email techsupport@grizzly.com.

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FOR MODELS MANUFACTURED SINCE 1/13 #TS15614 PRINTED IN TAIWAN

MACHINE DATA SHEET

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G0555LANV
14" DELUXE BANDSAW, ANNIVERSARY EDITION

Product Dimensions:

Weight	229 lbs.
Width (side-to-side) x Depth (front-to-back) x Height	27 x 30 x 67-1/2 in.
Foot Print (Length x Width)	23-1/2 x 16-1/2 in.

Shipping Dimensions:

Carton #1

Type	Cardboard Box
Content	Machine
Weight	205 lbs.
Length x Width x Height	46 x 22 x 19 in.

Carton #2

Type	Cardboard Box
Content	Stand
Weight	42 lbs.
Length x Width x Height	29 x 24 x 9 in.

Electrical:

Required Requirement	110V or 220V, Single-Phase, 60 Hz
Prewired Voltage	110V
Full Load Current Rating	11A at 110V, 5.5A at 220V
Minimum Circuit Size	15A
Switch	ON/OFF Push-Button Switch w/Padlock
Cord Length	10 ft.
Cord Gauge	16 AWG
Plug Included	Yes
Included Plug Type	NEMA 5-15
Recommended Plug Type	NEMA 6-15 for 220V

Motors:

Main

Type	TEFC Capacitor-Start Induction
Horsepower	1 HP
Phase	Single-Phase
Amps	11A/5.5A
Speed	1725 RPM
Power Transfer	Belt Drive
Bearings	Shielded and Permanently Sealed

Main Specifications:

Operation Information

Bandsaw Size	14 in.
Blade Speeds	1800, 3100 FPM
Table Tilt	Left 10, Right 45 deg.

Cutting Capacities

Maximum Cutting Height	6 in.
Maximum Capacity Left of Blade	13-1/2 in.

Blade Information

Standard Blade Length	93-1/2 in.
Blade Width Range	1/8 – 3/4 in.
Upper Blade Guides	Ball Bearing
Lower Blade Guides	Ball Bearing
Guide Post Size	0.865 in.
Guide Post Type	Solid Steel

Table Information

Table Length	14 in.
Table Width	14 in.
Table thickness	1-1/2 in.
Floor to Table Height	43 in.

Fence Information

Locks in Front	Yes
Locks in Rear	No
Adjustable for Blade Lead	Yes

Costruction

Table	Precision-Ground Cast Iron
Rip Fence	Extruded Aluminum and Cast Iron
Base	Pre-Formed Steel
Body	Cast Iron
Upper Wheel	Computer-Balanced Cast Iron
Lower Wheel	Computer-Balanced Cast Iron
Tire	Rubber
Wheel Cover	Pre-Formed Steel
Paint	Powder Coated

Other Related Information

Wheel Diameter	13-3/4 in.
Wheel Width	1-3/16 in.
Number of Dust Ports	1
Dust Port Size	4 in.
Mobile Base	T23376

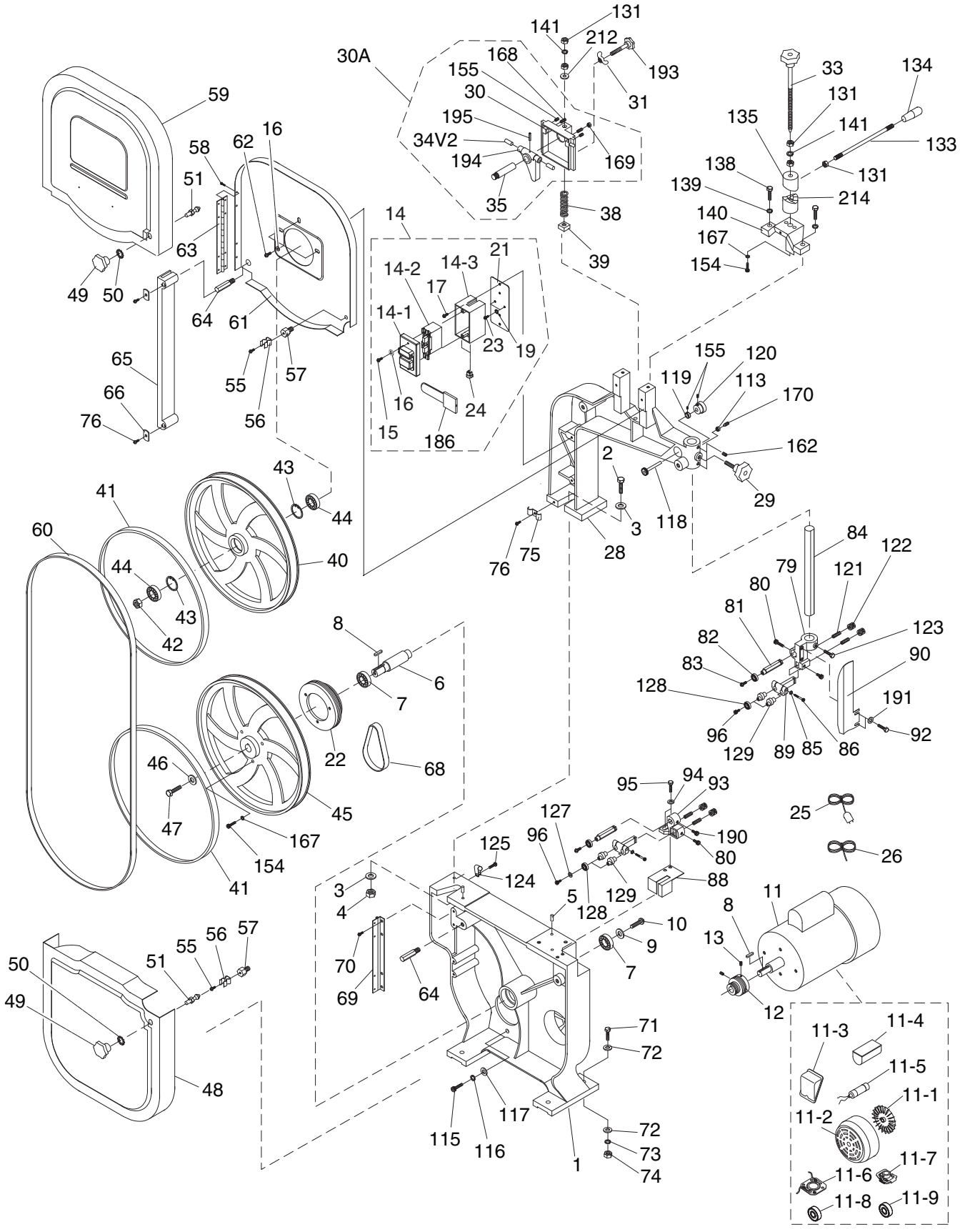
Other Specifications:

CSA Certified	Yes
Country of Origin	Taiwan
Warranty	1 Year
Serial Number Location	Machine ID Label on Lower Wheel Cover
Customer Assembly & Setup Time	1-1/2 hrs.

Features:

Black Powder-Coat Paint and a Unique 30-Year Anniversary Design
Computer-Balanced Cast-Iron Wheels
Rack-and-Pinion Guide Post Adjustment for Upper Blade Guides
Rock-Solid T-Shape Fence Design
Upper and Lower Ball Bearing Blade Guides
Hinged Wheel Covers
4" Dust Port
Quick-Release Blade Tension
Included Miter Gauge, Fence, and 3/8" Blade
6" Riser Block Available

Main Parts



Please Note: *We do our best to stock replacement parts whenever possible, but we cannot guarantee that all parts shown here are available for purchase. Call* ***(800) 523-4777*** *or visit our online parts store at* ***www.grizzly.com*** *to check for availability.*

Main Parts List

REF	PART #	DESCRIPTION
1	P0555LANV001	BASE (BLACK)
2	PB64	HEX BOLT 5/8-11 X 2-1/2
3	PW14	FLAT WASHER 5/8
4	PN04	HEX NUT 5/8-11
5	P0555LX005	GUIDE PIN 6 X 15MM
6	P0555LX006	LOWER WHEEL SHAFT
7	P6204-2RS	BALL BEARING 6204-2RS
8	PK23M	KEY 5 X 5 X 25
9	PW07	FLAT WASHER 5/16
10	PB32	HEX BOLT 5/16-18 X 5/8
11	P0555LX011	MOTOR 1HP 110V/220V 1-PH
11-1	P0555LX011-1	MOTOR FAN
11-2	P0555LX011-2	FAN COVER
11-3	P0555LX011-3	WIRING BOX
11-4	P0555LX011-4	CAPACITOR COVER
11-5	P0555LX011-5	S CAPACITOR 300M 125V
11-6	P0555LX011-6	CONTACTOR PLATE
11-7	P0555LX011-7	CENTRIFUGAL SWITCH 1725 RPM
11-8	P6205-2RS	BALL BEARING 6205-2RS
11-9	P6204-2RS	BALL BEARING 6204-2RS
12	P0555LX012	MOTOR PULLEY (J5-TYPE)
13	PSS07	SET SCREW 1/4-20 X 1/2
14	P0555LX014	PUSH BUTTON SWITCH ASSY
14-1	P0555LX014-1	SWITCH COVER
14-2	P0555LX014-2	SWITCH CONTROL
14-3	P0555LX014-3	SWITCH BOX
15	PHTEK40	TAP SCREW #10 X 1
16	PW04M	FLAT WASHER 10MM
17	PS22	PHLP HD SCR 10-24 X 5/8
19	PTLW08M	EXT TOOTH WASHER 10MM
21	P0555LX021	SWITCH PLATE
22	P0555LX022	WHEEL PULLEY (J5-TYPE)
23	PS18	PHLP HD SCR 10-24 X 1/4
24	P0555LX024	STRAIN RELIEF
25	P0555LX025	POWER CORD 16G 3W 6FT 5-15P
26	P0555LX026	MOTOR CORD 16G 3W
28	P0555LANV028	UPPER FRAME ARM (BLACK)
29	P0555LX029	STAR KNOB BOLT 5/16-18 X 3/4
30	P0555LX030	SLIDING HOUSING
30A	P0555LX030A	SLIDING HOUSING ASSY
31	PWN03	WING NUT 5/16-18
33	P0555LX033	TENSION BOLT 3/8-16 X 11-5/8
34V2	P0555LX034V2	PIVOT PIN W/FLAT SIDE V2.07.12
35	P0555LX035	UPPER WHEEL SHAFT
38	P0555LX038	COMPRESSION SPRING
39	P0555LX039	INDICATOR NUT 3/8 X 16
40	P0555LX040	UPPER WHEEL
41	P0555LX041	WHEEL TIRE
42	PN01	HEX NUT 1/2-20
43	PR21M	INT RETAINING RING 35MM
44	P6202-2RS	BALL BEARING 6202-2RS
45	P0555LX045	LOWER WHEEL
46	PW07	FLAT WASHER 5/16

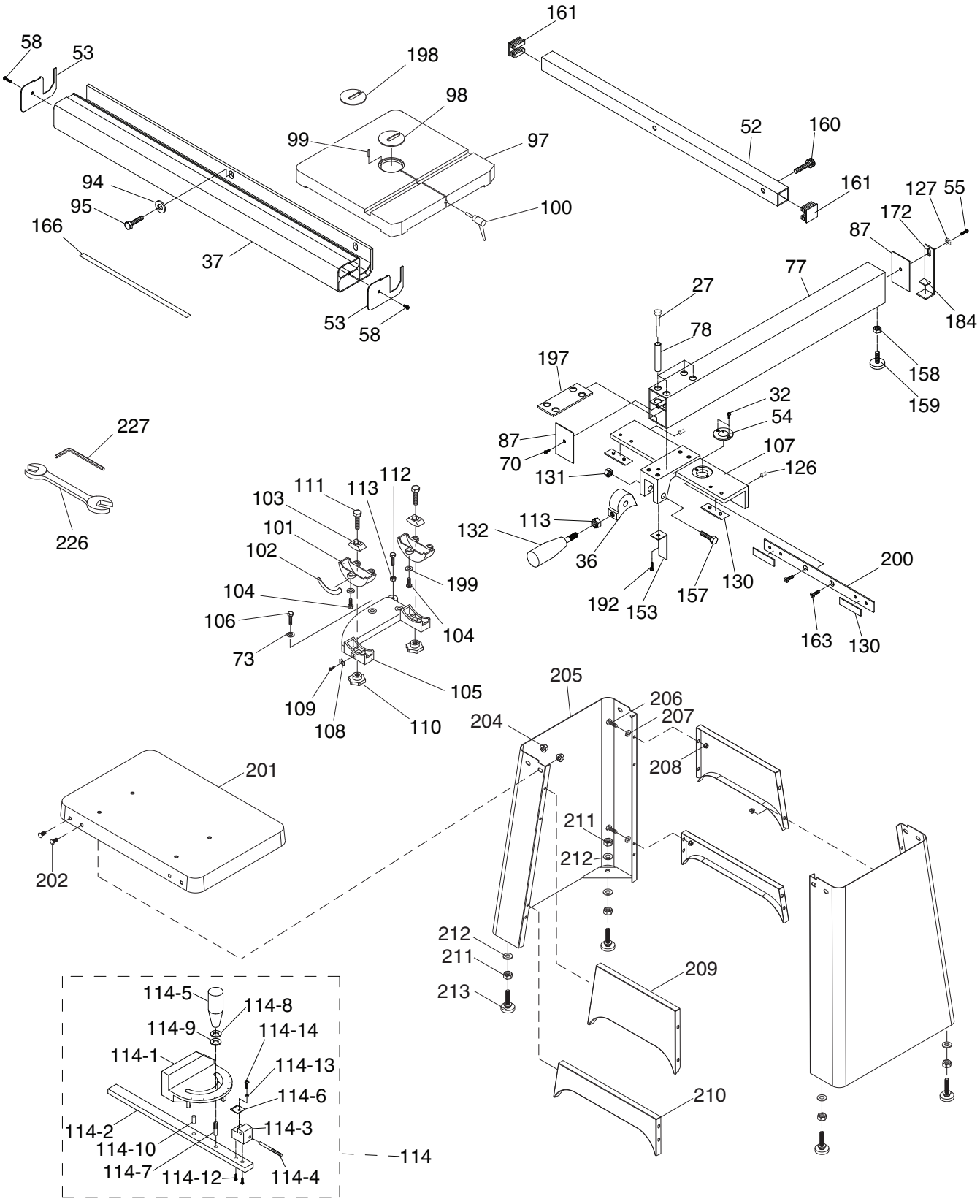
REF	PART #	DESCRIPTION
47	PB104	HEX BOLT 5/16-18 X 3/4 LH
48	P0555LANV048	LOWER WHEEL COVER (BLACK)
49	P0555LX049	KNOB 5/16-18
50	PTLW03M	INT TOOTH WASHER 8MM
51	P0555LX051	STUD LATCH
55	PS01	PHLP HD SCR 10-24 X 1/2
56	P0555LX056	CATCH
57	P0555LX057	LOCATING BOLT
58	PHTEK7	TAP SCREW #8 X 3/8
59	P0555LANV059	FRONT UPPER WHEEL COVER (BLACK)
60	P0555LX060	SAW BLADE 93-1/2 X 3/8 X 6TPI HOOK
61	P0555LANV061	REAR UPPER COVER (BLACK)
62	PFS03	FLANGE SCREW 10-24 X 3/8
63	P0555LANV063	UPPER HINGE (BLACK)
64	P0555LX064	STANDOFF STUD (HEX MF)
65	P0555LANV065	SAW BLADE GUARD (BLACK)
66	P0555LX066	BLADE GUARD WASHER #10
68	P0555LX068	RIBBED V-BELT 200J5
69	P0555LANV069	LOWER HINGE (BLACK)
70	PS06	PHLP HD SCR 10-24 X 3/8
71	PB11	HEX BOLT 5/16-18 X 1-1/2
72	PW07	FLAT WASHER 5/16
73	PLW01	LOCK WASHER 5/16
74	PN02	HEX NUT 5/16-18
75	P0555LX075	CORD CLAMP
76	PS01	PHLP HD SCR 10-24 X 1/2
79	P0555LX079	UPPER BLADE GUIDE CASTING
80	PCAP04	CAP SCREW 1/4-20 X 1/2
81	P0555LX081	BEARING ARBOR
82	P6000-2RS	BALL BEARING 6000-2RS
83	PFH09	FLAT HD SCR 1/4-20 X 5/16
84	P0555LX084	GUIDE POST
85	PLW03	LOCK WASHER #10
86	PCAP110	CAP SCREW 10-24 X 1-3/4
88	P0555LX088	LOWER BLADE GUIDE BRACKET
89	P0555LX089	GUIDE SHAFT BRACKET
90	P0555LANV090	UPPER BLADE GUARD (ORANGE)
92	PS06	PHLP HD SCR 10-24 X 3/8
93	P0555LX093	LOWER BRACKET POST
94	PW06	FLAT WASHER 1/4
95	PB05	HEX BOLT 1/4-20 X 3/4
96	PCAP109	CAP SCREW 10-32 X 1/4
113	PN02	HEX NUT 5/16-18
115	PB03	HEX BOLT 5/16-18 X 1
116	PLW01	LOCK WASHER 5/16
117	PW07	FLAT WASHER 5/16
118	P0555LX118	PINION SHAFT
119	P0555LX119	LOCK COLLAR
120	P0555LX120	GUIDE POST CONTROL KNOB
121	PSS100	SET SCREW 5/16-24 X 1-1/2
122	P0555LX122	ADJUST NUT
123	PCAP01	CAP SCREW 1/4-20 X 5/8
124	P0555LX124	CORD CLAMP 3/8

Main Parts List

REF	PART #	DESCRIPTION
125	PS01	PHLP HD SCR 10-24 X 1/2
127	PW03	FLAT WASHER #10
128	P608-2RS	BALL BEARING 608-2RS
129	P0555LX129	ECCENTRIC
131	PN08	HEX NUT 3/8-16
133	P0555LX133	STUD-UDE 3/8-16 X 10 1, 3/4
134	P0555LX134	PLASTIC HANDLE 3/8-16
135	P0555LX135	UPPER CLUTCH
138	PB12	HEX BOLT 5/16-18 X 1-1/4
139	PLW01	LOCK WASHER 5/16
140	P0555LX140	CLUTCH SUPPORT BRACKET
141	PLW04	LOCK WASHER 3/8
154	PCAP06	CAP SCREW 1/4-20 X 1
155	PSS04	SET SCREW 1/4-20 X 5/16

REF	PART #	DESCRIPTION
162	P0555LX162	BALL PLUNGER 1/4-20 X 1/2
167	PLW02	LOCK WASHER 1/4
168	PSS12	SET SCREW 1/4-20 X 1
169	PN05	HEX NUT 1/4-20
170	P0555LX170	DOG PT SET SCR 5/16-18 X 1/2
186	P0555LX186	SWITCH PADLOCK
190	PCAP17	CAP SCREW 1/4-20 X 3/8
191	PW02M	FLAT WASHER 5MM
193	P0555LX193	KNOB BOLT 5/16-18 X 2
194	P0555LX194	SHAFT BRACKET
195	PRP73M	ROLL PIN 4 X 30
212	PW02	FLAT WASHER 3/8
214	P0555LX214	LOWER CLUTCH

Table, Fence, & Stand Parts



Table, Fence, & Stand Parts List

REF	PART #	DESCRIPTION
27	PCAP43	CAP SCREW 1/4-20 X 2-1/2
32	PS28M	PHLP HD SCR M8-1.25 X 30
36	P0555LX036	LOCK CAM
37	P0555LX037	FRONT FENCE RAIL
52	P0555LX052	REAR FENCE RAIL
53	P0555LX053	FRONT RAIL END CAP
54	P0555LX054	MAGNIFYING LENS
55	PS01	PHLP HD SCR 10-24 X 1/2
58	PHTEK7	TAP SCREW #8 X 3/8
70	PS06	PHLP HD SCR 10-24 X 3/8
73	PLW01	LOCK WASHER 5/16
77	P0555LX077	FENCE
78	P0555LX078	SPACER
87	P0555LX087	FENCE END CAP
94	PW06	FLAT WASHER 1/4
95	PB05	HEX BOLT 1/4-20 X 3/4
97	P0555LANV097	TABLE (ORANGE SIDE)
98	P0555LX098	TABLE INSERT (LARGE SLOT)
99	PRP15M	ROLL PIN 3 X 8
100	P0555LX100	TABLE LOCK PIN
101	P0555LX101	TRUNNION
102	P0555LX102	TILT SCALE
103	P0555LX103	TRUNNION CLAMP SHOE
104	PB19	HEX BOLT 1/4-20 X 1/2
105	P0555LX105	TRUNNION BASE
106	PB12	HEX BOLT 5/16-18 X 1-1/4
107	P0555LX107	FENCE CARRIAGE ALUMINUM
108	P0555LX108	POINTER
109	PS18	PHLP HD SCR 10-24 X 1/4
110	P0555LX110	STAR KNOB 3/8-16
111	PB58	HEX BOLT 3/8-16 X 2
112	PB22	HEX BOLT 5/16-18 X 1-3/4
113	PN02	HEX NUT 5/16-18
114	P0555LX114	MITER GAUGE ASSY
114-1	P0555LX114-1	MITER GAUGE BODY
114-2	P0555LX114-2	MITER BAR
114-3	P0555LX114-3	STOP BLOCK
114-4	P0555LX114-4	STOP DOWEL
114-5	P0555LX114-5	MITER HANDLE 1/4-20
114-6	P0555LX114-6	SCALE PLATE
114-7	P0555LX114-7	STUD-SE 1/4-20 X 1-1/8 1/2

REF	PART #	DESCRIPTION
114-8	P0555LX114-8	FLAT WASHER 1/4 PLASTIC
114-9	PW06	FLAT WASHER 1/4
114-10	P0555LX114-10	STUD-SE 1/4-20 X 3/4 1/4
114-12	PFH08	FLAT HD SCR 10-24 X 1/2
114-13	PW02M	FLAT WASHER 5MM
114-14	PS01	PHLP HD SCR 10-24 X 1/2
126	PSS02	SET SCREW 5/16-18 X 3/8
127	PW03	FLAT WASHER #10
130	P0555LX130	BEARING PAD
131	PN08	HEX NUT 3/8-16
132	P0555LX132	HANDLE BOLT 5/16-18
153	P0555LX153	CAM WEAR PLATE
157	PB58	HEX BOLT 3/8-16 X 2
158	PN01M	HEX NUT M6-1
159	P0555LX159	RUB FOOT M6-1.0
160	PCAP01	CAP SCREW 1/4-20 X 5/8
161	P0555LX161	REAR RAIL END CAP
163	PFH19	FLAT HD SCR 1/4-20 X 3/8
166	P0555LX166	FENCE SCALE
172	P0555LX172	L-BRACE
184	P0555LX184	FENCE PAD
192	PFS03	FLANGE SCREW 10-24 X 3/8
197	P0555LX197	FENCE MOUNTING PLATE
198	P0555LX198	TABLE INSERT (SMALL SLOT)
199	PW06	FLAT WASHER 1/4
200	P0555LX200	FENCE ADJUSTMENT PLATE
201	P0555LANV201	STAND TOP (BLACK)
202	PCB01	CARRIAGE BOLT 5/16-18 X 5/8
204	PFN02	FLANGE NUT 5/16-18
205	P0555LANV205	STAND SIDE (BLACK)
206	PB02	HEX BOLT 1/4-20 X 5/8
207	PW06	FLAT WASHER 1/4
208	PFN01	FLANGE NUT 1/4-20
209	P0555LANV209	UPPER STAND BRACE (BLACK)
210	P0555LANV210	LOWER STAND BRACE (BLACK)
211	PN08	HEX NUT 3/8-16
212	PW02	FLAT WASHER 3/8
213	P0555LX213	STAND FOOT 3/8-16 X 2
226	PWR1012	WRENCH 10 X 12MM OPEN-END
227	PAW05M	HEX WRENCH 5MM

Labels & Cosmetics

REF	PART #	DESCRIPTION
215	P0555LANV215	MACHINE ID LABEL CSA
216	PLABEL-23	BANDSAW DOOR WARNING LABEL
217	P0555LANV217	3OTH ANNIVERSARY LABEL
218	PPAINT-25	PANTONE 151C ORANGE TOUCH-UP PAINT
219	P0555LANV219	MODEL NUMBER LABEL (PANTONE 151C)
220	P0555LANV220	GRIZZLY.COM LABEL (PANTONE 151C)

REF	PART #	DESCRIPTION
221	PPAINT-26	ANNIV EDITION BLACK TOUCH-UP PAINT
222	P0555LANV222	GRIZZLY BEAR LABEL 6" WIDE
223	PLABEL-14A	ELECTRICITY LABEL
224	PLABEL-11A	EYE INJURY WARNING LABEL
225	PLABEL-12A	READ MANUAL LABEL

⚠WARNING

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine MUST replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or www.grizzly.com.

MODEL G0555LX
14" DELUXE BANDSAW
OWNER'S MANUAL
(For models manufactured since 01/12)

C SA US
177335

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#KN14662 PRINTED IN TAIWAN

⚠ WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.

Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.

⚠ WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

Table of Contents

INTRODUCTION 2
Manual Accuracy 2
Contact Info 2
Machine Description 2
Identification 3
Machine Data Sheet 4

SECTION 1: SAFETY 6
Safety Instructions for Machinery 6
Additional Safety for Bandsaws 8

SECTION 2: POWER SUPPLY 9
Availability 9
Full-Load Current Rating 9
Circuit Information 9
Circuit Requirements for 110V 9
Circuit Requirements for 220V 9
Grounding Requirements 10
Extension Cords 11
Voltage Conversion 11

SECTION 3: SET UP 12
Set Up Safety 12
Needed for Setup 12
Unpacking 12
Inventory 13
Cleanup 14
Site Considerations 15
Assembly 16
Adjustment Overview 19
Blade Tracking 20
Dust Collection 22
Power Connection 22
Test Run 23
Tensioning Blade 23
The Flutter Method 24
The Deflection Method 24
Adjusting Blade Support Bearings 25
Adjusting Blade Guide Bearings 26
Table Tilt Calibration 27
Aligning Table 28
Aligning Fence 29

SECTION 4: OPERATIONS 30
Operation Overview 30
Straight Cuts 31
Irregular Cuts 31
Basic Cutting Tips 31
Disabling & Locking Switch 31
Workpiece Inspection 32
Guide Post 32
Table Tilt 33
Blade Speed 33
Blade Information 34
Blade Dimensions 34
Changing Blade 36
Ripping 37
Crosscutting 38
Resawing 38
Cutting Curves 39
Stacked Cuts 39

SECTION 5: ACCESSORIES 40

SECTION 6: MAINTENANCE 43
Schedule 43
Cleaning 43
Lubricating 43
Redressing Rubber Tires 43

SECTION 7: SERVICE 44
Troubleshooting 44
Motor & Electrical 44
Cutting Operations 45
Miscellaneous 45
V-Belt Tension 46
Checking V-Belt Tension 46
Tensioning V-Belt 46
Replacing V-Belt 47
Shimming Table 47
Wheel Alignment 48
Checking Wheel Alignment 48
Shimming a Wheel 49
Upper Wheel Lateral Adjustment 49
Blade Lead 50
Fence Scale Calibration 51
Blade Tensioner 52

SECTION 8: WIRING 53
Wiring Safety Instructions 53
Electrical Locations 54
110V (Prewired) Wiring Diagram 55
220V (Rewired) Wiring Diagram 56

SECTION 9: PARTS 57
Main 57
Table, Fence, & Stand 60
Labels 62

WARRANTY AND RETURNS 65

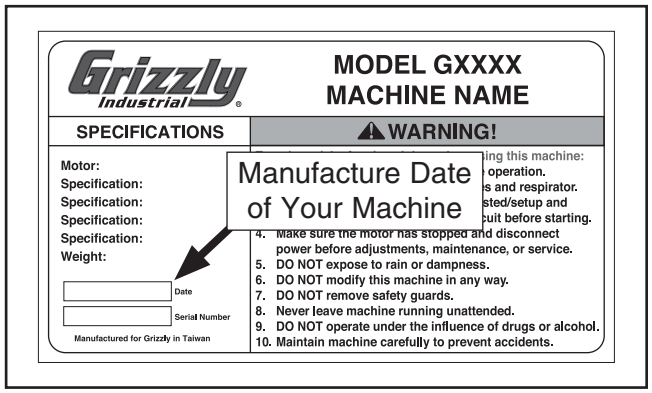
INTRODUCTION

Manual Accuracy

We are proud to offer this manual with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes we still make an occasional mistake.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual**. If you find this to be the case, and the difference between the manual and machine leaves you in doubt, check our website for the latest manual update or call technical support for help.

Before calling, find the manufacture date of your machine by looking at the date stamped into the machine ID label (see below). This will help us determine if the manual version you received matches the manufacture date of your machine.



For your convenience, we post all available manuals and manual updates for free on our website at **www.grizzly.com**. Any updates to your model of machine will be reflected in these documents as soon as they are complete.

Contact Info

We stand behind our machines. If you have any questions or need help, use the information below to contact us. Before contacting, please get the serial number and manufacture date of your machine. This will help us help you faster.

Grizzly Technical Support
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Email: techsupport@grizzly.com

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069
Email: manuals@grizzly.com

Machine Description

The bandsaw is a versatile woodworking tool that is used to perform a wide variety of cuts in wood stock, such as rip cuts, cross cuts, bevel cuts, miter cuts, circular cuts, contour cuts, stacked pattern cuts, etc.

The bandsaw blade is a continuous metal band wrapped around two rotating wheels, which performs the cut as it passes through the workpiece and table.

The Model G0555LX has 6" of cutting height, a 13½" left of the blade cutting capacity, and a 1 HP motor; this bandsaw is perfect for any shop. Thoughtful engineering makes this saw a pleasure to use. The Model G0555LX bandsaw includes convenient controls, a 4" dust port, computer balanced cast iron wheels, and an easy-to-read tension scale. Also included are a fence, a miter gauge, and a saw blade.

Identification

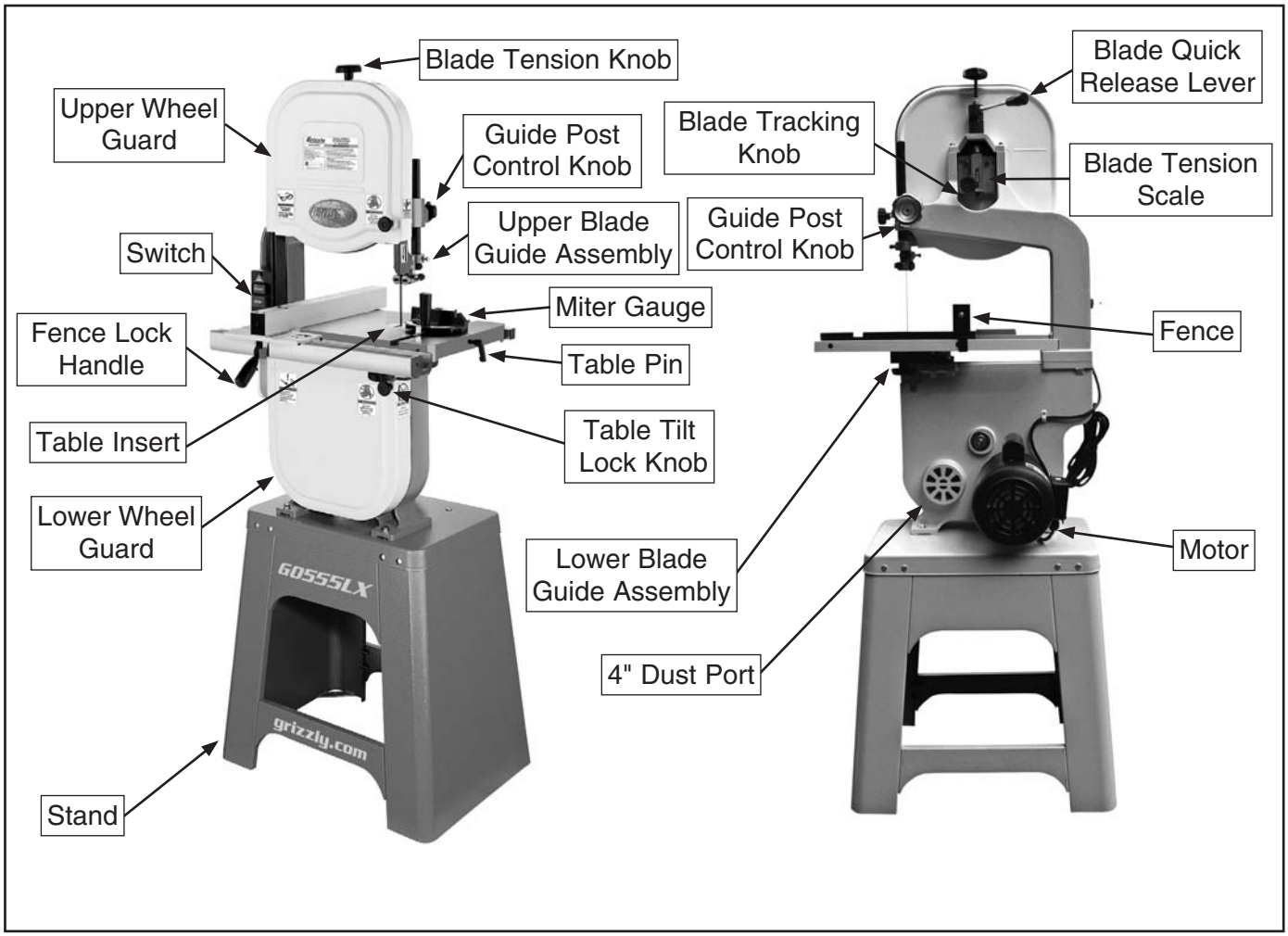


Figure 1. G0555LX identification.

⚠WARNING

For Your Own Safety, Read Instruction Manual Before Operating Bandsaw

a) **Wear eye protection.**
b) **Do not remove jammed cutoff pieces until blade has stopped.**
c) **Maintain proper adjustment of blade tension, blade guides, and thrust bearings.**
d) **Adjust upper guide to just clear workpiece.**
e) **Hold workpiece firmly against table.**

MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

MODEL G0555LX 14" DELUXE BANDSAW

Product Dimensions:

Weight..... 229 lbs.
Width (side-to-side) x Depth (front-to-back) x Height..... 27 x 30 x 67-1/2 in.
Footprint (Length x Width)..... 23-1/2 x 16-1/2 in.

Shipping Dimensions:

Carton #1

Type..... Cardboard
Content..... Machine
Weight..... 205 lbs.
Length x Width x Height..... 46 x 22 x 19 in.

Carton #2

Type..... Cardboard
Content..... Stand
Weight..... 42 lbs.
Length x Width x Height..... 29 x 24 x 9 in.

Electrical:

Power Requirement..... 110V, Single-Phase, 60 Hz
Prewired Voltage..... 110V
Full-Load Current Rating..... 11A at 110V; 5.5A at 220V
Minimum Circuit Size..... 15A
Switch..... On/Off Push Button
Switch Voltage..... 110V/220V
Cord Length..... 10 ft.
Cord Gauge..... 16 AWG
Plug Included..... Yes
Included Plug Type..... NEMA 5-15
Recommended Plug/Outlet Type..... NEMA 6-15 for 220V

Motors:

Main

Type..... TEFC Capacitor Start Induction
Horsepower..... 1 HP
Voltage..... 110V/220V
Phase..... Single-Phase
Amps..... 11A at 110V, 5.5A at 220V
Speed..... 1725 RPM
Cycle..... 60 Hz
Number of Speeds..... 1
Power Transfer ..... Belt Drive
Bearings..... Shielded and Lubricated Ball Bearings

Main Specifications:

Operation

Bandsaw Size..... 14 in.
Blade Speeds..... 1800, 3100 FPM
Table Tilt..... Left 10, Right 45 deg.

Cutting Capacities

Maximum Cutting Height	6 in.
Max Capacity Left of Blade	13-1/2 in.

Blade Information

Standard Blade Length	93-1/2 in.
Blade Width Range	1/8 – 3/4 in.
Upper Blade Guides	7/8" Ball Bearing
Lower Blade Guides	7/8" Ball Bearing
Guide Post Size	0.865 in.
Guide Post Type	Solid Steel

Table Information

Table Length	14 in.
Table Width	14 in.
Table Thickness	1-1/2 in.
Floor to Table Height	43 in.

Fence Information

Locks in Front	Yes
Locks in Rear	No
Adjustable for Blade Lead	Yes

Construction

Table	Precision Ground Cast Iron
Rip Fence	Extruded Aluminum and Cast Iron
Base	Pre-Formed Steel
Body	Cast Iron
Upper Wheel	Cast Iron
Lower Wheel	Cast Iron
Tire	Rubber
Wheel Cover	Pre-Formed Steel
Paint	Powder Coated

Other Related Information

Wheel Diameter	13-3/4 in.
Wheel Width	1-3/16 in.
Number of Dust Ports	1
Dust Port Size	4 in.
Mobile Base	T23376

Other Specifications:

CSA Certified	Yes
Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	Machine ID Label on Top Cover
Customer Assembly & Setup Time	1-1/2 Hours

Features:

Computer-Balanced Cast-Iron Wheels
Rack-and-Pinion Guide Post Adjustment for Upper Blade Guides
Rock-solid T-shape fence design
Upper and Lower Ball Bearing Blade Guides
Hinged Wheel Covers
4" Dust Port
Quick Release Blade Tension
Included Miter Gauge, Fence, and 3/8" Blade
6" Riser Block Available

SECTION 1: SAFETY

For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures. Always use common sense and good judgement.

⚠DANGER **Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.**

⚠WARNING **Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.**

⚠CAUTION **Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.**

NOTICE **This symbol is used to alert the user to useful information about proper operation of the machine.**

Safety Instructions for Machinery

⚠WARNING

OWNER'S MANUAL. Read and understand this owner's manual BEFORE using machine.

TRAINED OPERATORS ONLY. Untrained operators have a higher risk of being hurt or killed. Only allow trained/supervised people to use this machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

DANGEROUS ENVIRONMENTS. Do not use machinery in areas that are wet, cluttered, or have poor lighting. Operating machinery in these areas greatly increases the risk of accidents and injury.

MENTAL ALERTNESS REQUIRED. Full mental alertness is required for safe operation of machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.

ELECTRICAL EQUIPMENT INJURY RISKS. You can be shocked, burned, or killed by touching live electrical components or improperly grounded machinery. To reduce this risk, only allow qualified service personnel to do electrical installation or repair work, and always disconnect power before accessing or exposing electrical equipment.

DISCONNECT POWER FIRST. Always disconnect machine from power supply BEFORE making adjustments, changing tooling, or servicing machine. This prevents an injury risk from unintended startup or contact with live electrical components.

EYE PROTECTION. Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are not approved safety glasses.

⚠WARNING

WEARING PROPER APPAREL. Do not wear clothing, apparel or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to avoid accidental slips, which could cause loss of workpiece control.

HAZARDOUS DUST. Dust created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material, and always wear a NIOSH-approved respirator to reduce your risk.

HEARING PROTECTION. Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

REMOVE ADJUSTING TOOLS. Tools left on machinery can become dangerous projectiles upon startup. Never leave chuck keys, wrenches, or any other tools on machine. Always verify removal before starting!

INTENDED USAGE. Only use machine for its intended purpose and never make modifications not approved by Grizzly. Modifying machine or using it differently than intended may result in malfunction or mechanical failure that can lead to serious personal injury or death!

AWKWARD POSITIONS. Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

CHILDREN & BYSTANDERS. Keep children and bystanders at a safe distance from the work area. Stop using machine if they become a distraction.

GUARDS & COVERS. Guards and covers reduce accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly.

FORCING MACHINERY. Do not force machine. It will do the job safer and better at the rate for which it was designed.

NEVER STAND ON MACHINE. Serious injury may occur if machine is tipped or if the cutting tool is unintentionally contacted.

STABLE MACHINE. Unexpected movement during operation greatly increases risk of injury or loss of control. Before starting, verify machine is stable and mobile base (if used) is locked.

USE RECOMMENDED ACCESSORIES. Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

UNATTENDED OPERATION. To reduce the risk of accidental injury, turn machine ***OFF*** and ensure all moving parts completely stop before walking away. Never leave machine running while unattended.

MAINTAIN WITH CARE. Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. A machine that is improperly maintained could malfunction, leading to serious personal injury or death.

CHECK DAMAGED PARTS. Regularly inspect machine for any condition that may affect safe operation. Immediately repair or replace damaged or mis-adjusted parts before operating machine.

MAINTAIN POWER CORDS. When disconnecting cord-connected machines from power, grab and pull the plug—NOT the cord. Pulling the cord may damage the wires inside. Do not handle cord/plug with wet hands. Avoid cord damage by keeping it away from heated surfaces, high traffic areas, harsh chemicals, and wet/damp locations.

EXPERIENCING DIFFICULTIES. If at any time you experience difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.

⚠WARNING
Additional Safety for Bandsaws

BLADE CONDITION. Do not operate with dull, cracked or badly worn blade. Dull blades require more effort to perform the cut. Inspect blades for cracks and missing teeth before each use.

HAND PLACEMENT. Never position fingers or hands in line with the blade. If the workpiece or your hands slip, serious personal injury could occur.

WORKPIECE MATERIAL. This machine is intended for cutting natural and man-made wood products, and laminate covered wood products. This machine is NOT designed to cut metal, glass, stone, tile, etc.

BLADE REPLACEMENT. To avoid mishaps that could result in operator injury, make sure the blade teeth face down toward the table and the blade is properly tensioned and tracked before operating.

BLADE SPEED. Moving the workpiece against a blade that is not at full speed could cause kickback. Always allow the blade to come to full speed before starting the cut.

GUARDS. The blade guard protects the operator from the moving bandsaw blade. ONLY operate this bandsaw with the blade guard installed.

CUTTING TECHNIQUES. Plan your cuts so you always cut out of the wood. DO NOT back the workpiece away from the blade while the saw is running. If you need to back the work out, turn the bandsaw OFF and wait for the blade to come to a complete stop, and DO NOT twist or put excessive stress on the blade while backing the work away.

LEAVING WORK AREA. Never leave a machine running unattended. Allow the bandsaw to come to a complete stop and use the padlock to disable the machine before you leave it unattended.

FEED RATE. To avoid the risk of the workpiece slipping and causing operator injury, always feed stock evenly and smoothly. DO NOT force or twist the blade while cutting, especially when sawing small curves.

SMALL WORKPIECE HANDLING. Always support/feed the workpiece with push sticks, jig, vise, or some type of clamping fixture. If your hands slip during a cut while holding small workpieces with your fingers, amputation or laceration injuries could occur.

BLADE CONTROL. To avoid serious personal injury, DO NOT attempt to stop or slow the blade with your hand or the workpiece. Allow the blade to stop on its own.

⚠WARNING

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to decrease the risk of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

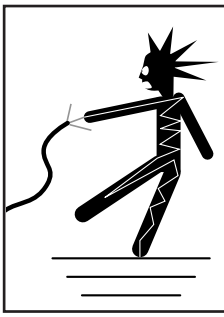
⚠CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

SECTION 2: POWER SUPPLY

Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by an electrican or qualified service personnel in accordance with all applicable codes and standards.



⚠WARNING

Electrocution, fire, or equipment damage may occur if machine is not correctly grounded and connected to the power supply.

Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating at 110V..... 11 Amps
Full-Load Current Rating at 220V .... 5.5 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the requirements in the following section.

Circuit Information

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)

⚠CAUTION

For your own safety and protection of property, consult an electrician if you are unsure about wiring practices or electrical codes in your area.

Note: *The circuit requirements listed in this manual apply to a dedicated circuit—where only one machine will be running at a time. If this machine will be connected to a shared circuit where multiple machines will be running at the same time, consult a qualified electrician to ensure that the circuit is properly sized for safe operation.*

Circuit Requirements for 110V

This machine is prewired to operate on a 110V power supply circuit that has a verified ground and meets the following requirements:

Nominal Voltage 110V/120V
Cycle ..... 60 Hz
Phase ..... Single-Phase
Circuit Rating ..... 15 Amps
Plug/Receptacle ..... NEMA 5-15

Circuit Requirements for 220V

This machine can be converted to operate on a 220V power supply (refer to **Voltage Conversion** instructions). This power supply must have a verified ground and meet the following requirements:

Nominal Voltage 220V/240V
Cycle ..... 60 Hz
Phase ..... Single-Phase
Circuit Rating ..... 15 Amps
Plug/Receptacle ..... NEMA 6-15

Grounding Requirements

This machine MUST be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

⚠WARNING

Serious injury could occur if you connect the machine to power before completing the setup process. DO NOT connect to power until instructed later in this manual.

For 110V operation: This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug (see following figure). The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances.

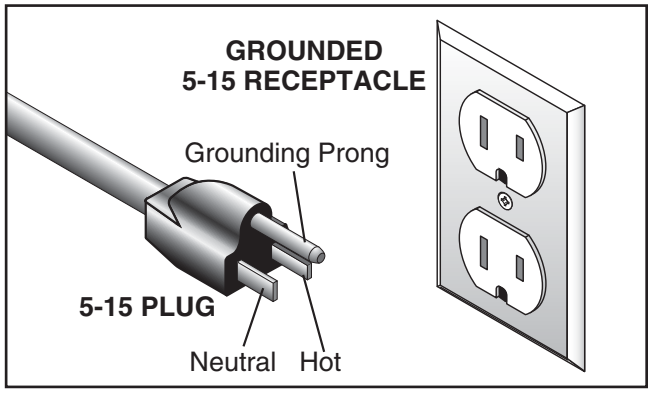
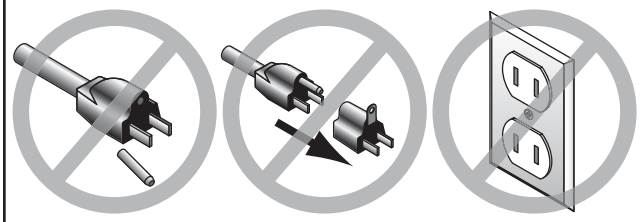


Figure 2. Typical 5-15 plug and receptacle.

⚠CAUTION



SHOCK HAZARD!

Two-prong outlets do not meet the grounding requirements for this machine. Do not modify or use an adapter on the plug provided—if it will not fit the outlet, have a qualified electrician install the proper outlet with a verified ground.

For 220V operation: The plug specified under "Circuit Requirements for 220V" on the previous page has a grounding prong that must be attached to the equipment-grounding wire on the included power cord. The plug must only be inserted into a matching receptacle (see following figure) that is properly installed and grounded in accordance with all local codes and ordinances.

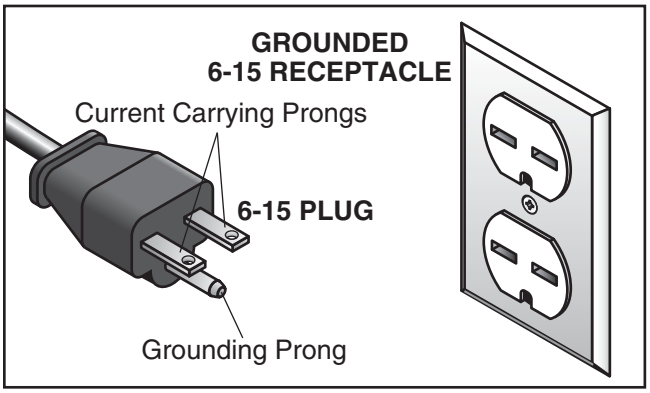


Figure 3. Typical 6-15 plug and receptacle.

Extension Cords

We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

Extension cords cause voltage drop, which may damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

Any extension cord used with this machine must contain a ground wire, match the required plug and receptacle, and meet the following requirements:

Minimum Gauge Size .....14 AWG
Maximum Length (Shorter is Better).....50 ft.

Voltage Conversion

The voltage conversion MUST be performed by an electrician or a qualified service personnel. The voltage conversion is a two step process involving rewiring the motor for the new voltage and installing a new plug according to the manufacturer's instructions.

Note: *If the diagram included on the motor conflicts with the one in this manual, the motor may have changed since the manual was printed. If this is the case, use the diagram provided inside the motor wiring junction box instead of the one provided in this manual.*

Items Needed:	**Qty**
Wire Nut 14 AWG	1
Electrical Tape	As Needed
Nema 6-15 Plug	1

To convert the machine to 220V:

1. DISCONNECT MACHINE FROM POWER!
2. Remove the 5-15 plug from the cord.
3. Remove the two wire nuts from the wires shown in **Figure 4**.

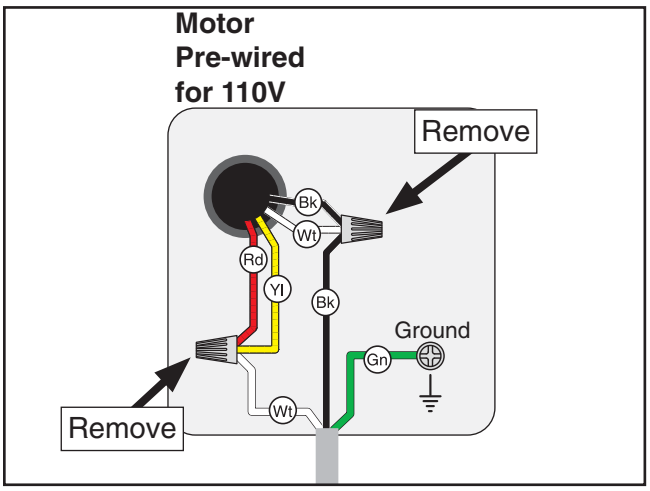


Figure 4. Motor pre-wired for 110V.

4. Re-wire the motor as shown in **Figure 4**.

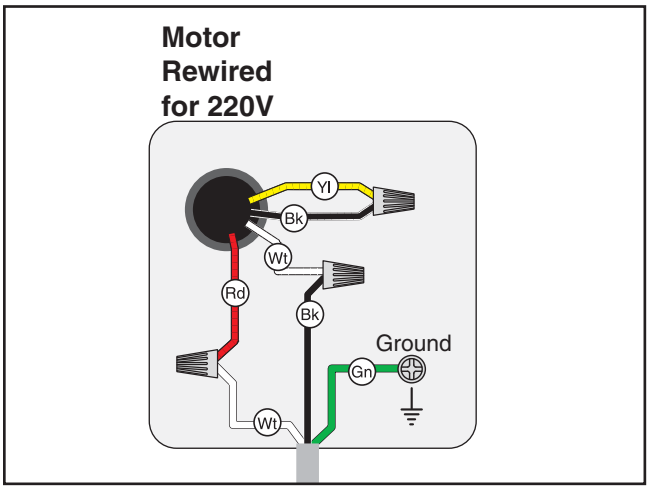
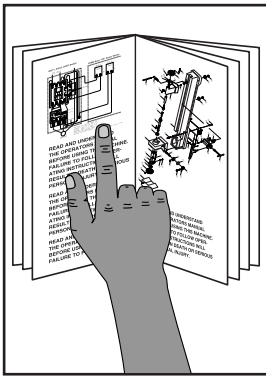


Figure 5. Motor rewired for 220V.

5. Tighten all wire nuts and secure them with electrical tape so they cannot vibrate loose during motor operation.
6. Install the 6-15 plug on the power cord per the plug manufacturer's instructions.

SECTION 3: SET UP

Set Up Safety



⚠WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!

⚠WARNING

Wear safety glasses during the entire set up process!

⚠WARNING

This machine and its components are very heavy. Get lifting help or use power lifting equipment such as a forklift to move heavy items.

Needed for Setup

The following are needed to complete the setup process, but are not included with your machine.

Description	Qty
• Additional People	As Needed
• Safety Glasses	1
• Disposable Shop Rags	As Needed
• Cleaner/Degreaser	As Needed
• Level	1
• Hex Wrench 5mm	1
• Wrench or Socket 10mm	2
• Wrench or Socket 13mm	2

Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover the machine is damaged, *please immediately call us at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, inventory the contents.

⚠WARNING

SUFFOCATION HAZARD!

Keep children and pets away from plastic bags or packing materials shipped with this machine. Discard immediately.

Inventory

The following is a description of the main components shipped with your machine. Lay the components out to inventory them.

If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

Inventory (see Figure 6)	Qty
A. Table	1
B. Saw Blade 93½" x ⅜" x 6 TPI	1
C. Bandsaw Body	2
D. Trunnion Base	1
E. Front Fence Rail	1
F. Rear Fence Rail	1
G. Miter Gauge Assembly	1
H. Fence Assembly	1
I. Trunnion Lock Knobs	2
J. Upper Stand Braces	2
K. Stand Top	1
L. Stand Sides	2
M. Lower Stand Braces	2
N. Hardware Bag	1
—Table Insert	1
—Hex Bolts 5/16"-18 x 1½" (Bandsaw)	4
—Hex Nuts 5/16"-18 (Bandsaw)	4
—Lock Washers 5/16" (Bandsaw)	4
—Flat Washers 5/16" (Bandsaw)	8
—Cap Screws ¼"-20 x ⅝" (Fence)	2
—Hex Bolts ¼"-20 x ¾" (Fence)	2
—Flat Washers ¼" (Fence)	2
—Hex Bolts ¼"-20 x ⅝" (Stand)	16
—Flat Washers ¼" (Stand)	16
—Flange Nuts (Stand)	16
—Stand Feet ⅜"-16 x 2" (Stand)	4
—Carriage Bolts 5/16"-18 x ⅝" (Stand)	8
—Flange Nuts 5/16"-18 (Stand)	8
—Hex Nuts ⅜"-16 (Stand Feet)	8
—Flat Washer ⅜" (Stand Feet)	8
—Combo Wrench 10 x 12mm	1
—Hex Wrench 5mm	1

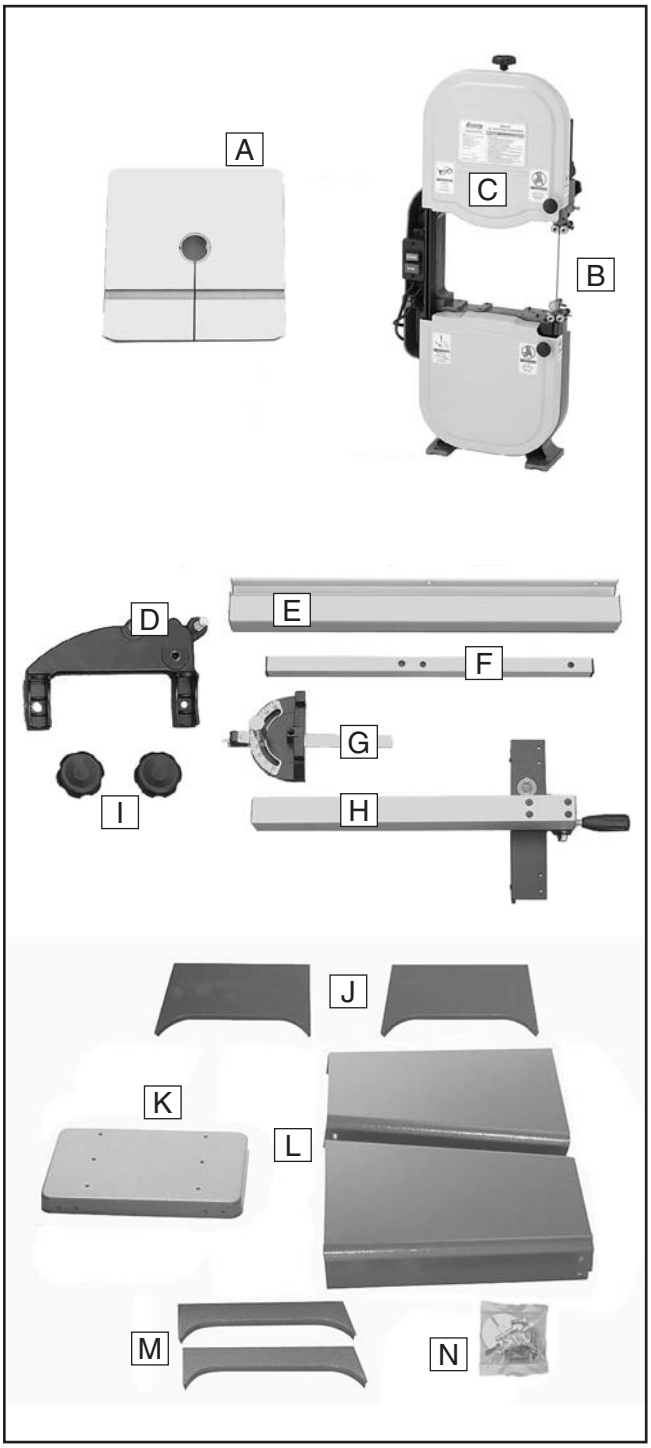


Figure 6. Main components inventory.

NOTICE

If you cannot find an item on this list, carefully check the machine and the packaging materials. Some of these items may be preinstalled for shipping or become misplaced during unpacking.

Cleanup

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

Before cleaning, gather the following:
- Disposable Rags
- Cleaner/degreaser (WD•40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

Basic steps for removing rust preventative:

1. Put on safety glasses.

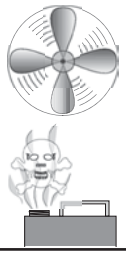
2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.

3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.

4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.

⚠WARNING

Gasoline or products with low flash points can explode or cause fire if used to clean machinery. Avoid cleaning with these products.



⚠CAUTION

Many cleaning solvents are toxic if concentrated amounts are inhaled. Only work in a well-ventilated area.

NOTICE

Avoid chlorine-based solvents, such as acetone or brake parts cleaner, that may damage painted surfaces. Test all cleaners in an inconspicuous area before using to make sure they will not damage paint.

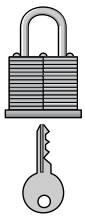
Site Considerations

Weight Load

Refer to the **Machine Data Sheet** for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

Space Allocation

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual. **See below for required space allocation.**



⚠CAUTION

Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.

Physical Environment

The physical environment where the machine is operated is important for safe operation and longevity of machine components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave access to a means of disconnecting the power source or engaging a lockout/tagout device, if required.

Lighting

Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.

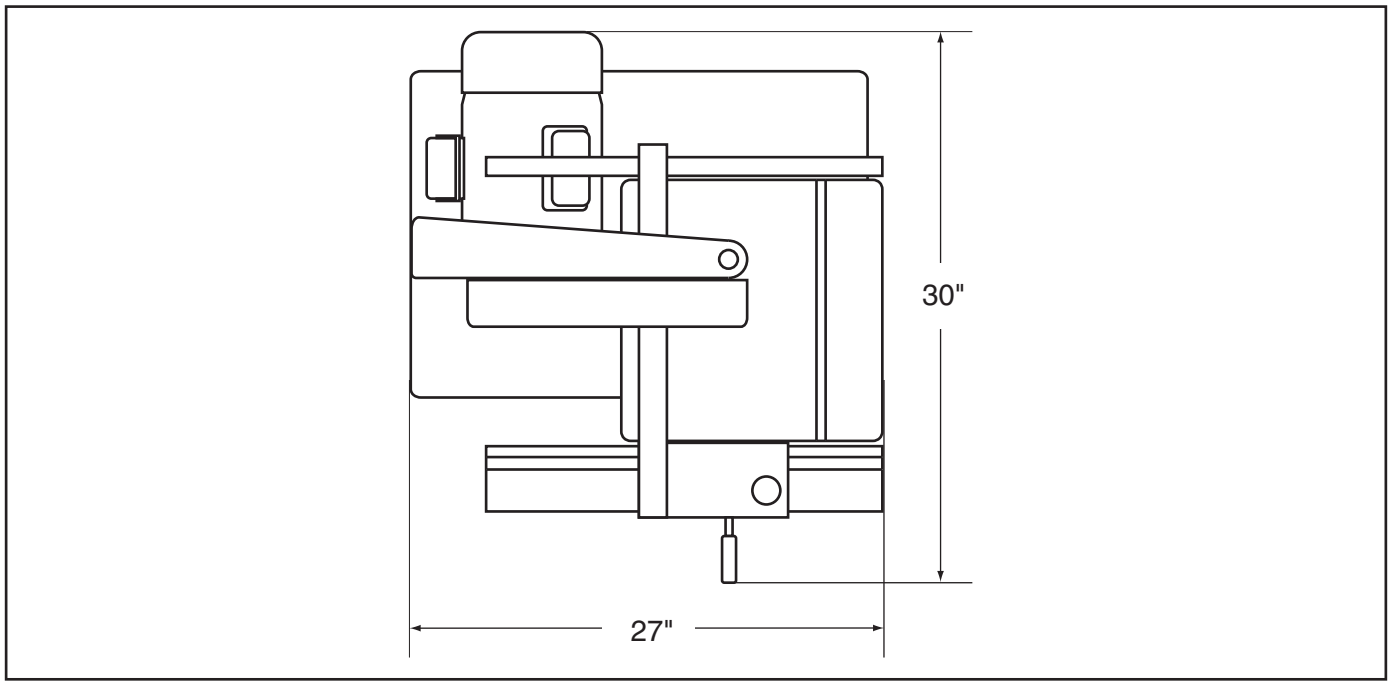


Figure 7. Minimum working clearances.

Assembly

⚠CAUTION

Some sheet metal parts may have sharp edges that can cause minor cuts. Please use care while handling them.

⚠CAUTION

The bandsaw is heavy and awkward to lift onto the stand. Get assistance from another person when lifting.

To assemble the bandsaw:

1. Lay one stand side flat on a piece of cardboard to prevent scratching the paint, then attach the upper and lower stand braces to one side, as shown in **Figure 8**, with (8) ¼"-20 x ⅝" hex bolts, (8) ¼" flat washers, and (8) ¼"-20 flange nuts.

   Note: *Only hand-tighten the stand fasteners during these initial steps. Once the stand is completely assembled you will be instructed to fully tighten all fasteners.*

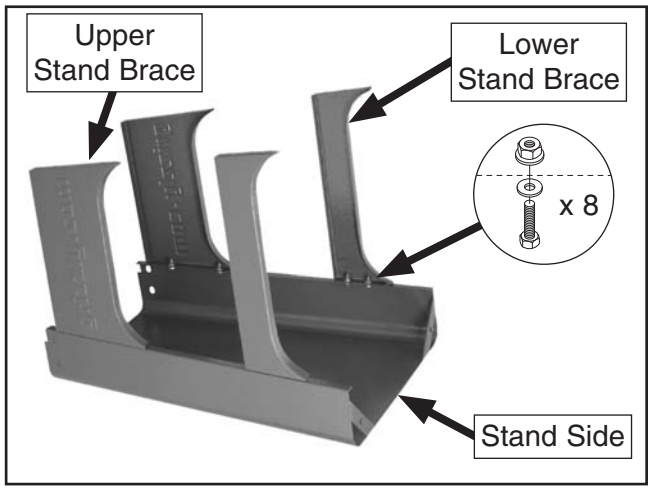


Figure 8. Upper and lower stand braces attached to the stand side.

2. Attach the remaining stand side to the assembly, as shown in **Figure 9**, with (8) ¼"-20 x ⅝" hex bolts, (8) ¼" flat washers, and (8) ¼"-20 flange nuts.

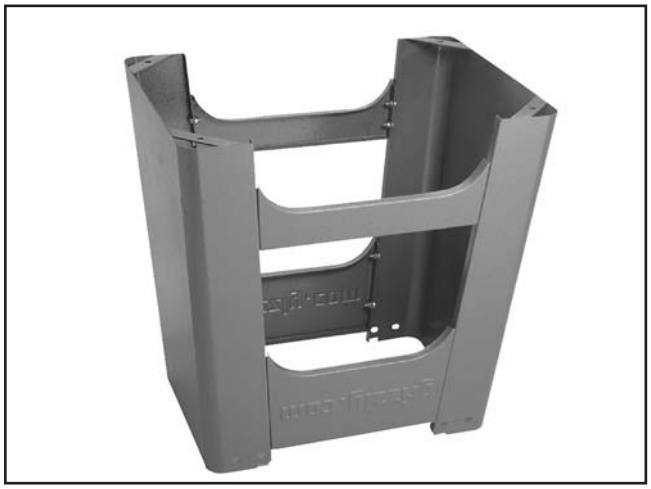


Figure 9. Second stand side attached.

3. Install the stand feet, as shown in **Figure 10**, in the bottom of the stand assembly, using a ⅜"-16 x 2" stand foot, (2) ⅜"-16 hex nuts and (2) ⅜" flat washers on each foot in the sequence shown.

   Note: *Adjust the feet so that they are approximately the same height—this will make leveling the stand easier in a later step.*

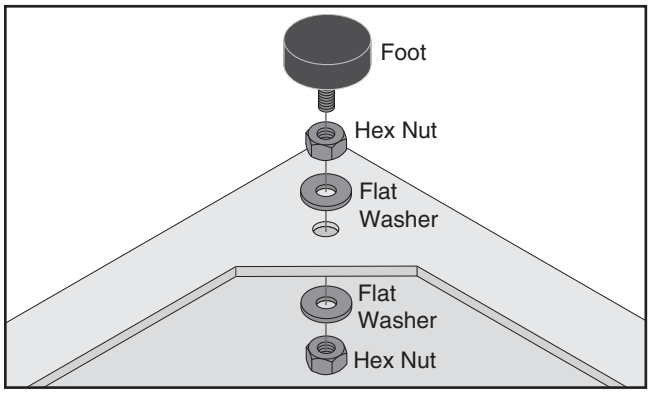


Figure 10. Stand foot installed (1 of 4).

4. Turn the stand assembly upright and attach the top, as shown in **Figure 11**, with (8) 5/16"-18 x 5/8" carriage bolts and (8) 5/16"-18 flange nuts.

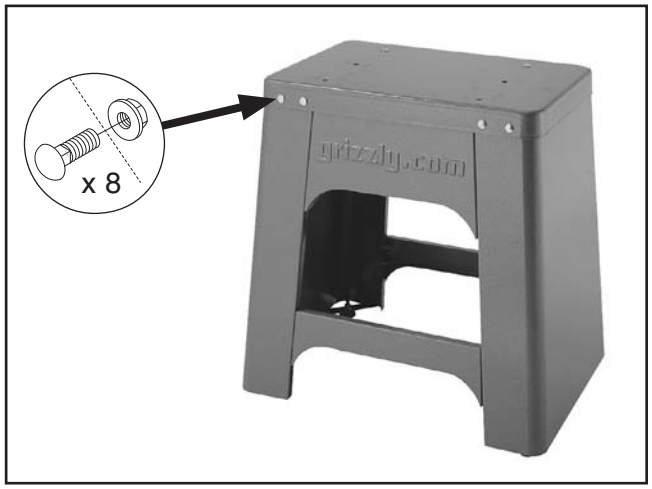


Figure 11. Stand top attached.

5. Square up the stand components and fully tighten all the fasteners.

6. Place the level on top of the stand assembly, as shown in **Figure 12**, then adjust the feet up or down to make the stand top level from side to side and front to back. Make sure that both hex nuts on the feet are tight against the stand assembly so they will not move.

Figure 12. Leveling the stand.

7. With the help of other people, lift the bandsaw assembly onto the stand and align the mounting holes. Have one person hold the bandsaw in place to keep it from fall until you can complete the next step.

8. Secure the bandsaw assembly to the stand with (4) 5/16"-18 x 1½" hex bolts, (4) 5/16" lock washers, (8) 5/16" flat washers, and (4) 5/16"-18 hex nuts, as shown in **Figure 13**.

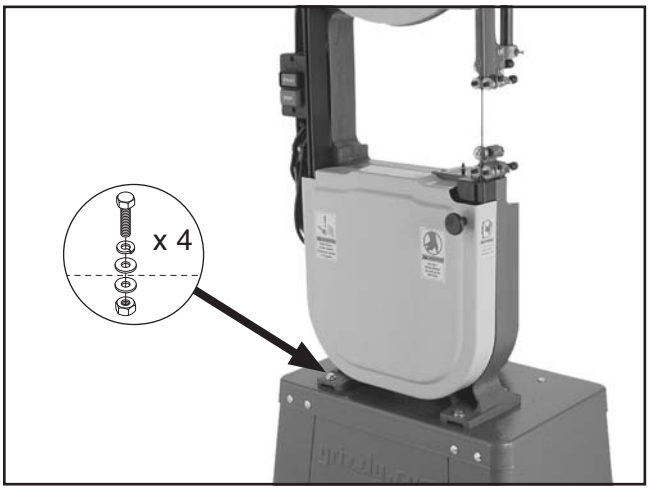


Figure 13. Bandsaw assembly attached to the stand.

9. Position the table trunnion on the bandsaw, as shown in **Figure 14**, then secure it with the (2) 5/16"-18 x 1¼" hex bolts and (2) 5/16" lock washers.

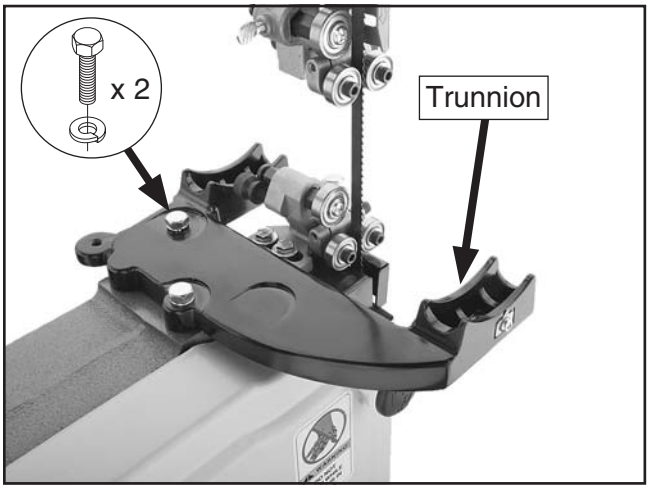


Figure 14. Trunnion installed.

10. Line up the table slot with the blade, then position the table so that the blade is in the center cut-out.

11. Rotate the table so that the table slot faces to the right, then insert the table bolts through the mounting holes in the trunnion base, as shown in **Figure 15**.

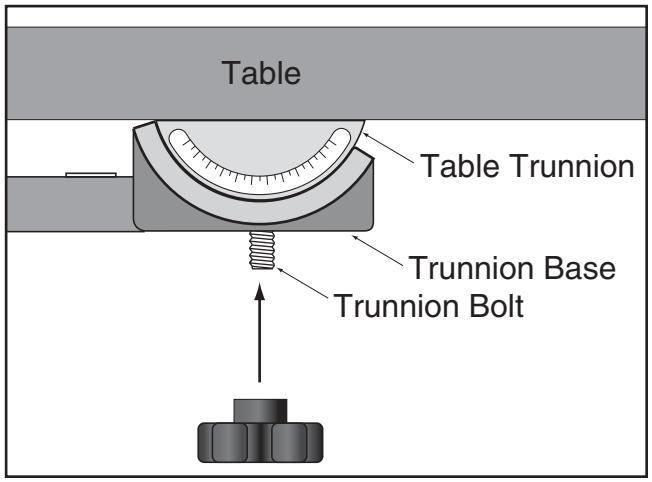


Figure 15. Installing the table onto the trunnion base.

12. Secure the table by fully threading the two trunnion lock knobs onto the table bolts.

13. Attach the rear fence rail to the rear of the table with (2) 1/4"-20 x 5/8" cap screws, as shown in **Figure 16**.

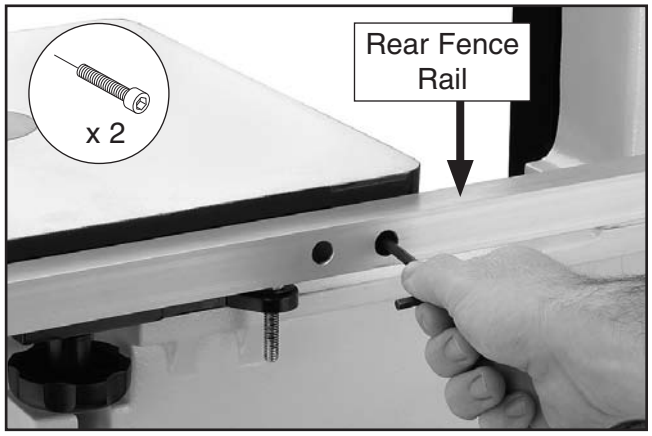


Figure 16. Installing rear fence rail.

14. Attach the front fence rail shown in **Figure 17**, with (2) 1/4"-20 x 3/4" hex bolts and 1/4" flat washers.

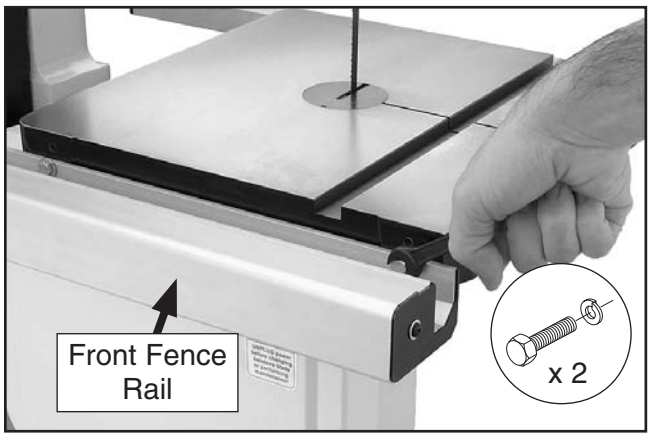


Figure 17. Installing front fence rail.

15. Pull the fence handle up and place the fence on the front fence rail, as shown in **Figure 18**.

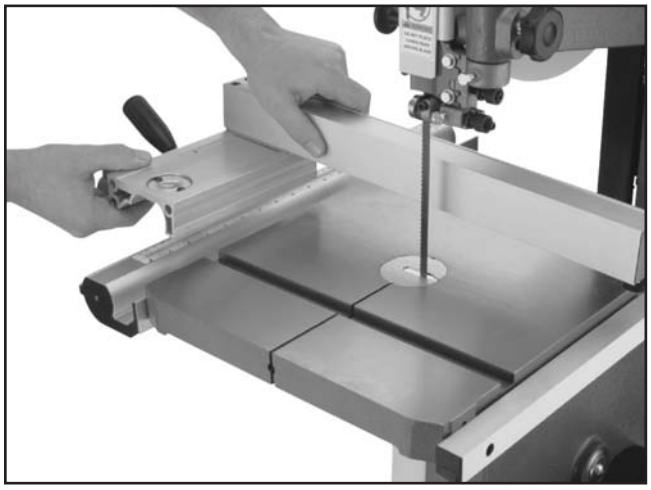


Figure 18. Installing fence onto rails.

16. Thread the M6-1 hex nut onto the fence rail pad, then thread it into the rear underside of the fence (see **Figure 19**) so that the fence rests the same height above the table along its full length. Tighten the hex nut against the fence to secure the setting.

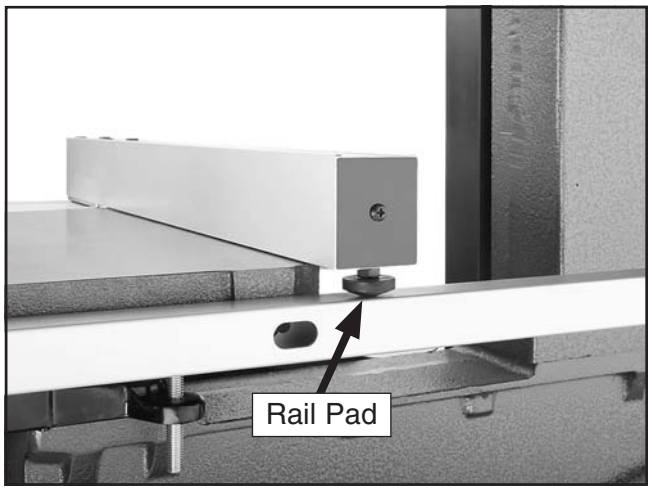


Figure 19. Fence rail pad installed.

17. Install the table insert and table pin, as show in **Figure 20**.

Important: *Make sure you re-install the table pin. This pin keeps the table surfaces on either side of the slot even with the changes in operating pressures and temperature changes.*

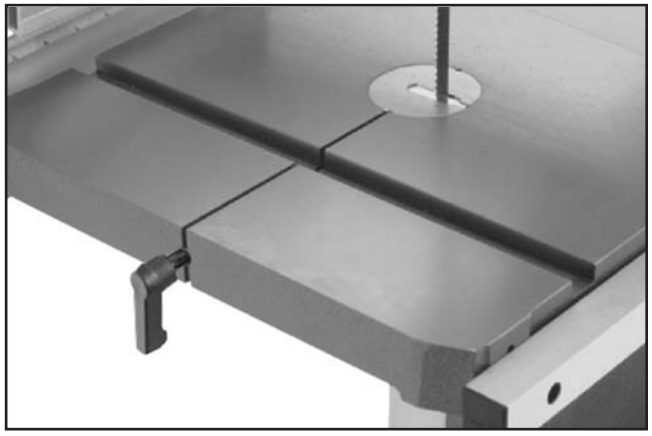


Figure 20. Table pin and insert installed.

Adjustment Overview

The bandsaw is one of the most versatile woodworking machines. As such it has multiple components that must be properly adjusted for the best cutting results.

For safety reasons some adjustments and test operations must be performed before performing other necessary adjustments. Below is an overview of all the adjustments and the order in which they should be performed.

Adjustment procedures include:

- Blade Tracking
- Dust Collection
- Power Connection
- Test Run
- Tension Blade
- Adjusting Blade Support Bearings
- Adjusting Blade Guide Bearings
- Table Tilt Calibration
- Aligning Table
- Aligning Fence

Blade Tracking

"Tracking" refers to how the blade rides on the bandsaw wheels. Proper tracking is important for maintaining bandsaw adjustments, achieving correct blade tension, and cutting accurately. Improper tracking reduces cutting accuracy, causes excess vibrations, and places stress on the blade and other bandsaw components. The shape of the wheels and the orientation of the wheels in relation to each other determine how the blade tracks.

Bandsaw wheels are either flat or crowned and both shapes track differently. The G0555LX has crowned wheels. As the wheels spin the blade naturally tracks to the highest point of the crown at the center of the wheel (see **Figure 21**).

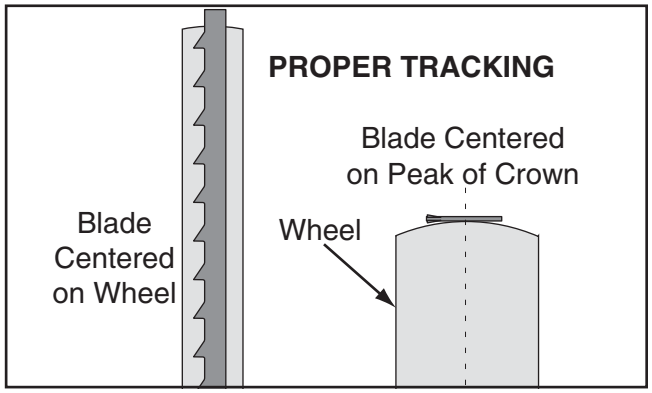


Figure 21. Blade centered on the crown of the wheel.

The wheels of the bandsaw must be aligned for the blade to track correctly on the crown of the wheel. Properly aligned wheels are parallel and coplanar (see **Figure 22**).

Improper blade tension and cutting practices can negatively affect blade tracking. Familiarizing yourself with the ideas and conditions described in **Figure 22** will help you recognize when your saws wheel alignment may need adjusted (refer to **Wheel Alignment** on **Page 48** for detailed instructions on adjusting the tracking).

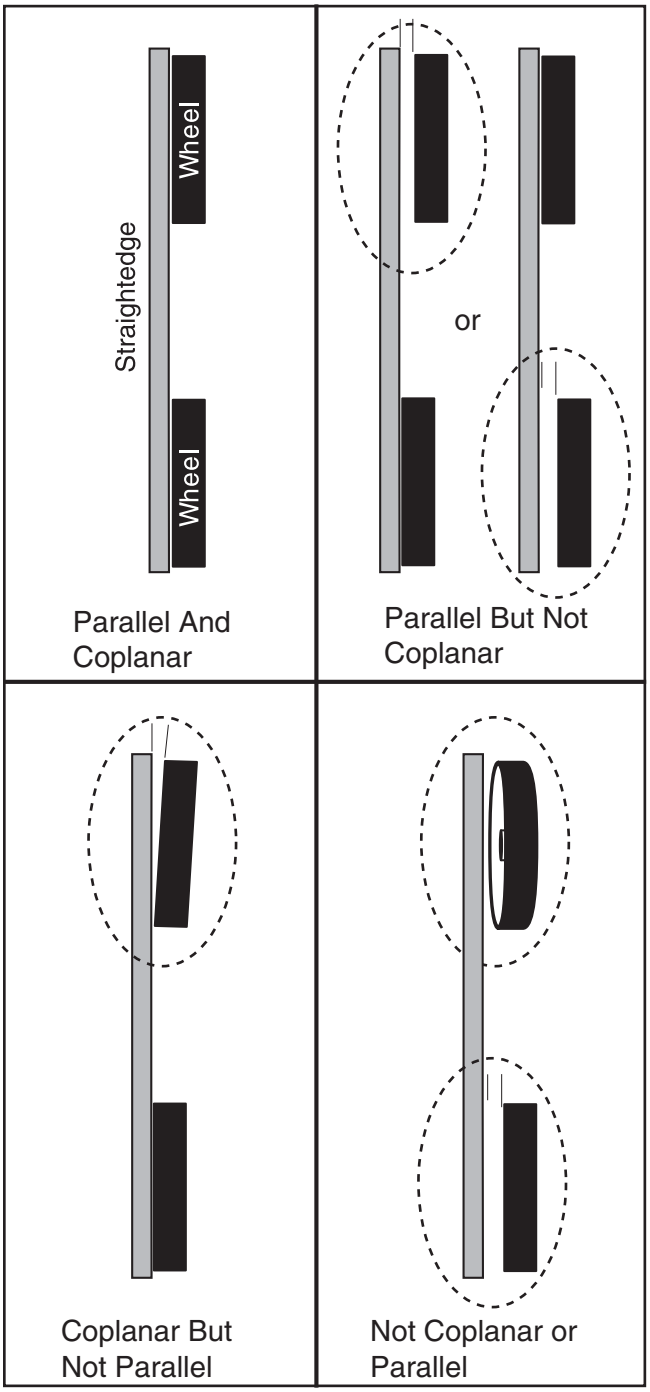


Figure 22. Wheel alignment and misalignment examples.

The wheels on the G0555LX were aligned at the factory, so center tracking is the only adjustment that needs to be performed when the saw is new. This adjustment is necessary turning the saw on or performing other adjustments.

To center track the blade:

1. DISCONNECT BANDSAW FROM POWER!

2. Adjust the upper and lower blade guides away from the blade (refer to **Adjusting Blade Guide Bearings** on **Page 26** for detailed instructions).

   Note: *When adjusting the blade tracking for the test run in this procedure, the blade must have a reasonable amount of tension to simulate operating conditions. After the test run is successfully completed, you will perform a thorough version of the following steps to more accurately tension the blade.*

3. Move the blade tension quick release lever all the way right (as viewed from the rear of the machine) to apply tension to the blade (see **Figure 23**).

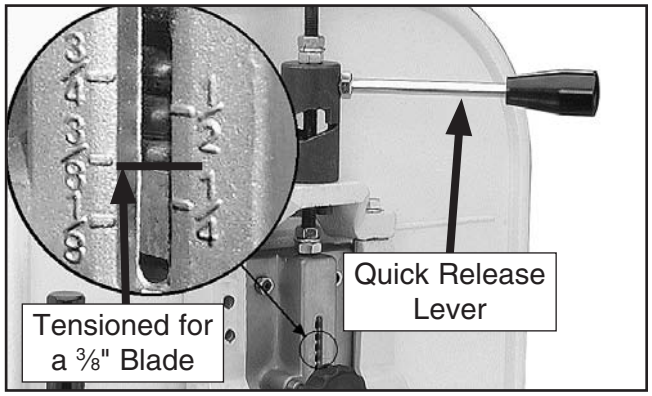


Figure 23. Example of tension applied for a ⅜" blade.

4. Use the tension knob on top of the bandsaw to bring the upper edge of the indicator block to the appropriate blade tension scale mark for the blade width (see **Figure 23**).

   Note: *If you are using the blade that was shipped with the machine, this would be ⅜".*

5. Open the upper wheel cover.

6. Rotate the upper wheel by hand several times and watch how the blade rides on the wheel crown (see **Figure 21** on **Page 19** for an illustration of this concept).

   —If the blade rides in the center of the upper wheel and is centered on the peak of the wheel crown, it is properly tracking and you are done with this procedure—proceed to **Dust Collection** on **Page 22**.

   —If the blade does is not properly tracking, then continue with this procedure to adjust it.

7. Loosen the wing nut on the tracking knob (see **Figure 24**).

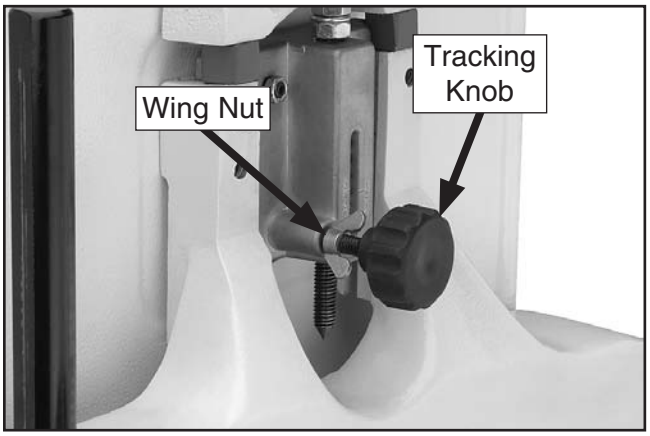


Figure 24. Tracking knob and wing nut.

8. Spin the upper wheel with one hand and slowly adjust the tracking knob with the other hand until the blade consistently tracks in the center of the wheel.

9. Tighten the wing nut to secure the setting, then spin the upper wheel several times to confirm the tracking. If necessary, repeat the adjustment procedure until the blade is tracking properly.

10. Re-adjust the blade guide bearings toward the blade (refer to **Adjusting Blade Guide Bearings** on **Page 26** for detailed instructions).

11. Close and secure the upper wheel cover before operating the bandsaw.

Dust Collection

⚠CAUTION

DO NOT operate this bandsaw without an adequate dust collection system. This bandsaw creates substantial amounts of wood dust while operating. Failure to use a dust collection system can result in short and long-term respiratory illness.

Recommended CFM at Dust Port: 400 CFM

Do not confuse this CFM recommendation with the rating of the dust collector. To determine the CFM at the dust port, you must consider these variables: (1) CFM rating of the dust collector, (2) hose type and length between the dust collector and the machine, (3) number of branches or wyes, and (4) amount of other open lines throughout the system. Explaining how to calculate these variables is beyond the scope of this manual. Consult an expert or purchase a good dust collection "how-to" book.

To connect a dust collection hose:

1. Fit the dust hose over the dust port, as shown in **Figure 25**, and secure it in place with a hose clamp.

2. Gently pull the hose to make sure it does not come off. A tight fit is necessary for proper performance.

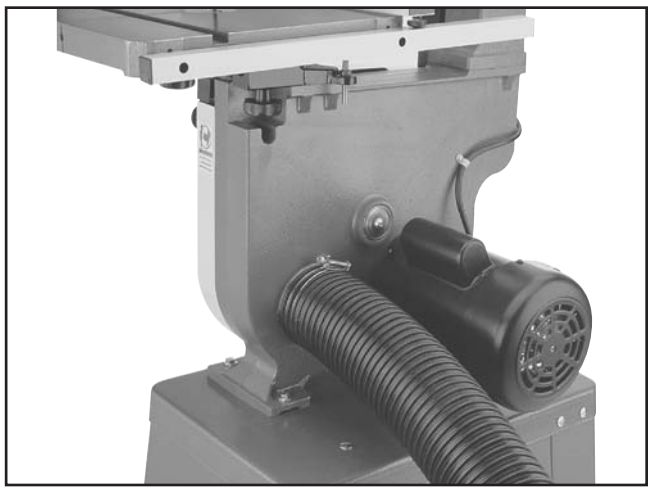


Figure 25. 4" dust hose attached to dust port.

Power Connection

After you have completed all previous setup instructions and circuit requirements, the machine is ready to be connected to the power supply.

To avoid unexpected startups or property damage, use the following steps whenever connecting or disconnecting the machine.

Connecting Power

1. Turn the machine power switch **OFF**.

2. Insert the power cord plug into a matching power supply receptacle. The machine is now connected to the power source.

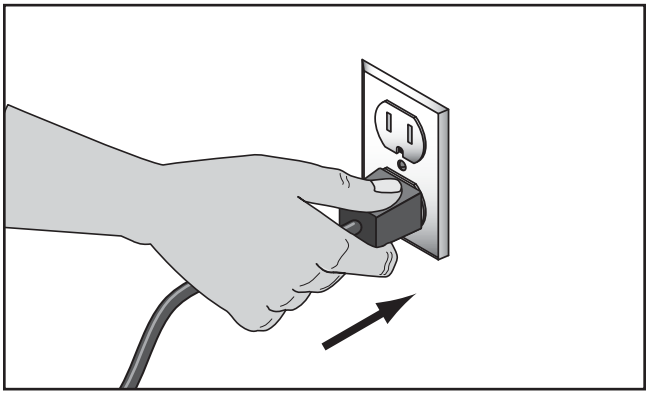


Figure 26. Connecting power.

Disconnecting Power

1. Turn the machine power switch **OFF**.

2. Grasp the molded plug and pull it completely out of the receptacle. Do not pull by the cord as this may damage the wires inside.

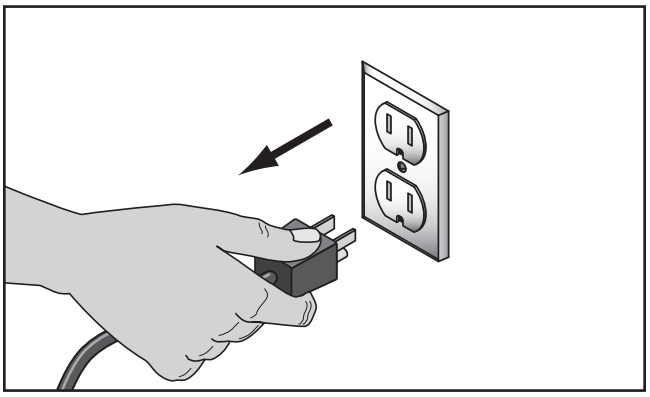


Figure 27. Disconnecting power.

Test Run

Once the assembly is complete, test run your machine to make sure it runs properly and is ready for regular operation.

The test run consists of verifying the following: 1) The motor powers up and runs correctly, and 2) the safety disabling mechanism on the switch works correctly.

If, during the test run, you cannot easily locate the source of an unusual noise or vibration, stop using the machine immediately, then review **Troubleshooting** on **Page 44**.

If you still cannot remedy a problem, contact our Tech Support at (570) 546-9663 for assistance.

To test run the machine:

1. Make sure you have read the safety instructions at the beginning of the manual and that the machine is set up properly.

2. Make sure all tools and objects used during setup are cleared away from the machine.

3. Verify that the machine is operating correctly by turning it ***ON***.

   —When operating correctly, the machine runs smoothly with little or no vibration or rubbing noises.

   —Investigate and correct strange or unusual noises or vibrations before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.

4. Turn the machine ***OFF***.

5. Insert the switch disabling padlock through the ON button, as shown in **Figure 28**.

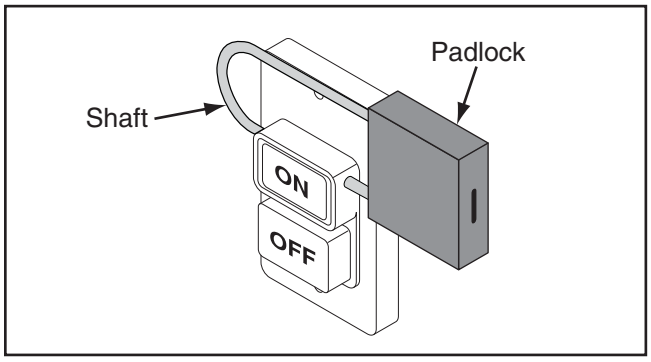


Figure 28. Switch disabling padlock inserted into ON button.

6. Press the ON button to test the disabling feature on the switch.

   —If the machine does not start, the switch disabling feature is working as designed.

   —If the machine does start, immediately stop it. The switch disabling feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

Tensioning Blade

A properly tensioned blade is essential for making accurate cuts, maximizing the life of the blade, and making other bandsaw adjustments. However properly tensioned blade will not compensate for cutting problems caused by too rapid of a feed rate, hardness variations between workpieces, and improper blade selection.

The method used to tension the blade is often a matter of preference. Described below are the flutter method and the deflection method. Either method will help safely tension the blade. Experience and personal preference will help you decide which method your prefer. Optimal cutting results for any workpiece are a combination of correct blade selection, proper blade tension, and an appropriate feed rate. Improper blade tension is unsafe, produces inaccurate and inconsistent results, and introduces unnecessary wear on bandsaw components. Over-tensioning the blade increases the chance of the blade breaking or wheel misalignment. Under-tensioned blades wander excessively while cutting and will not track properly during operation.

Note: *Tensioning the blade according to the blade tension scale before the **Test Run** was an approximate tension. The following procedures fine-tunes the blade tension.*

The Flutter Method

1. DISCONNECT BANDSAW FROM POWER.

2. Make sure the blade is properly center tracking as instructed in the **Blade Tracking** subsection previous on **Page 19**.

3. Raise the guide post all the way and move the upper and lower guide bearings away from the blade.

4. Engage the blade tension quick release lever to apply tension to the blade.

5. Connect the bandsaw to power, and turn the bandsaw ***ON***.

6 . Using the blade tension adjustment knob, slowly decrease blade tension until you see the blade start to flutter.

7. Slowly increase the tension until the blade stops fluttering, then tighten the blade tension adjustment knob and additional ⅛ to ¼ of a turn.

8. Look at what the tension gauge reads and use that as a guide for tensioning that specific blade in the future.

Note: *Do not rely on this setting for other blades or for long periods of time because all blades require specific tensioning and stretch with use. If you notice a decrease in performance at the setting repeat this procedure.*

*With extended use, the blade tensioning system may need to be reset. Refer to **Resetting Blade Tensioner** in the **Service** section in this manual for details.*

9. Disconnect the bandsaw from power.

10. Re-adjust blade guides as described in **Adjusting Blade Support Bearings** and **Adjusting Blade Guide Bearings** on **Pages 25– 26**.

The Deflection Method

The deflection method is much more subjective than the flutter method. Each blade will deflect differently and every user will determine what "moderate pressure" means. The following are general guidelines for tensioning the blade with this method.

To tension the bandsaw blade:

1. DISCONNECT BANDSAW FROM POWER.

2. Make sure the blade is properly tracking as instructed in the **Blade Tracking** subsection on **Page 19**.

3. Raise the guide post all the way and move the upper and lower guide bearings away from the blade.

4. Engage the blade tension quick release lever to apply tension to the blade.

5. Using moderate pressure, push the center of the blade sideways.

—If the blade deflects approximately ¼" it is properly tensioned. Proceed to **Step 7**.

—If the blade deflects less than ¼" it is over-tensioned. Turn the blade tensioning knob counter clockwise two full turns and repeat **Step 6**.

—If the blade deflects ¼" or more, the blade is not properly tensioned. Apply tension to the blade incrementally and repeat **Step 6** until properly tensioned.

6. Re-adjust blade guides as described in **Adjusting Blade Support Bearings** and **Adjusting Blade Guide Bearings** on **Pages 25– 26**.

NOTICE

When using different size blades, the blade tensioning system may need to be reset for correct operation. Refer to *Blade Tensioner* on *Page 52* for detailed instructions.

Adjusting Blade Support Bearings

The support bearings are positioned behind the blade on the blade guides and prevent it from deflecting backward during cutting operations. Proper adjustment of the support bearings is an important part of making accurate cuts and keeps the blade teeth from coming in contact with the blade guides while cutting.

There are support bearings on the upper and lower blade guide assemblies. Both adjust in the same manner.

Important: *The blade is tracking and tensioned correctly before performing this procedure.*

Tool Needed	**Qty**
Wrench 10mm	1
Feeler Gauge 0.016" (or Dollar Bill)	1

To adjust the support bearings:

1. DISCONNECT BANDSAW FROM POWER!

2. Familiarize yourself with the support bearing controls shown in **Figure 29**.

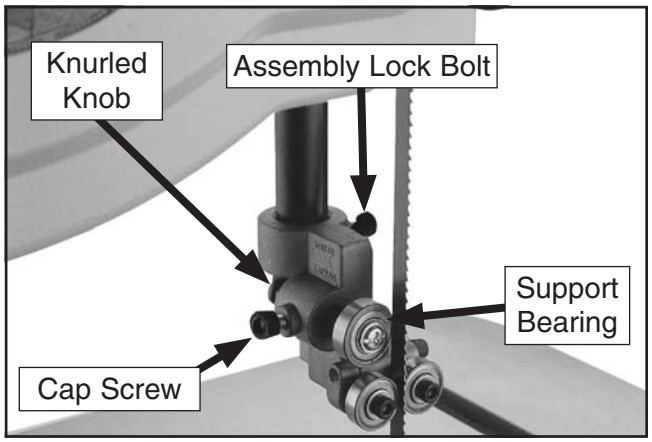


Figure 29. Upper support bearing assembly and controls.

3. Loosen the guide assembly lock bolt so that the support bearing can be rotated perpendicular to the blade in the next step.

4. Rotate the blade guide assembly until the face of the support bearing is perpendicular to the blade, as illustrated in the **Figure 30**.

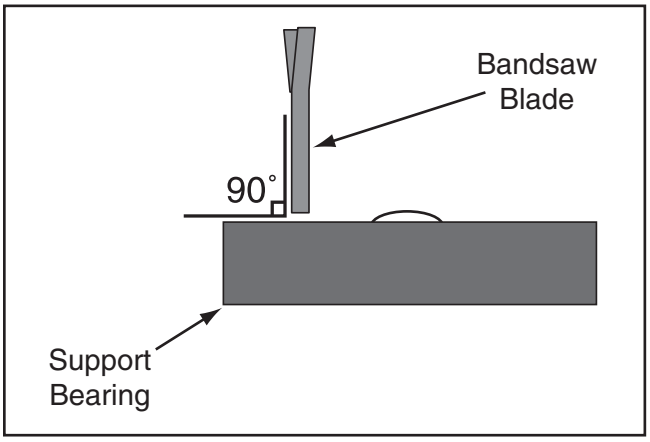


Figure 30. The face of the support bearing must be perpendicular (90°) to the blade.

5. Tighten the assembly lock bolt (see **Figure 29**).

6. Loosen the cap screw (see **Figure 29**) on the support bearing adjustment shaft.

7. Use the knurled knob to position the support bearing approximately 0.016" away from the back of the blade, as illustrated in **Figure 31**. This can be measured with a feeler gauge or a dollar bill.

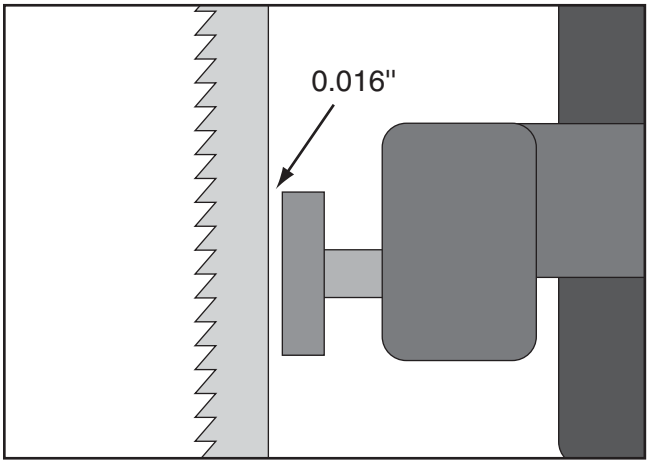


Figure 31. Blade should be aligned approximately 0.016" away from the bearing edge.

Tip: *To quickly gauge this setting, fold a crisp dollar bill in half twice (when folded tightly, four thicknesses of a dollar bill is approximately 0.016"). Place the folded dollar bill between the support bearing and the blade, as shown in* ***Figure 32****.*

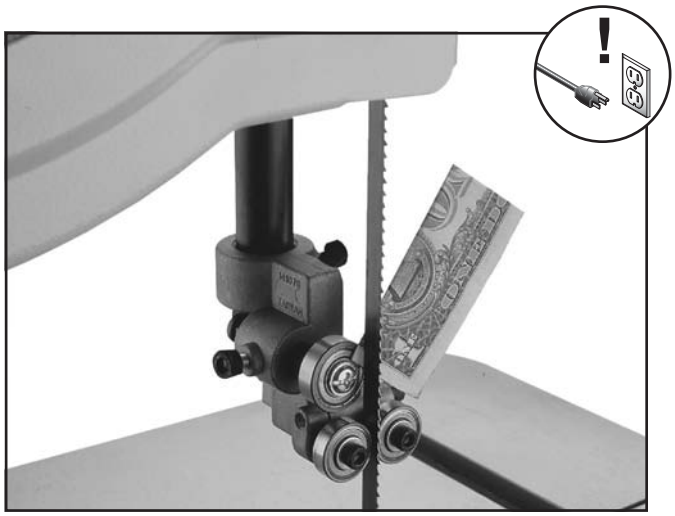


Figure 32. Dollar bill folded twice to make a quick 0.016" gauge.

8. Tighten the cap screw to lock the support bearing in place.

Adjusting Blade Guide Bearings

Properly adjusting the blade guides provides side-to-side support to help keep the blade straight while cutting.

There are blade guide bearings on the upper and lower blade guide assemblies. Both adjust in the same manner.

Important: *The blade is tracking and tensioned correctly before performing this procedure* (see **Tensioning Blade** on **Page 23**).

Tool Needed	**Qty**
Hex Wrench 4mm	2

To adjust the upper and lower blade guides:

1. DISCONNECT BANDSAW FROM POWER!

2. Familiarize yourself with the blade guide controls shown in **Figure 33**.

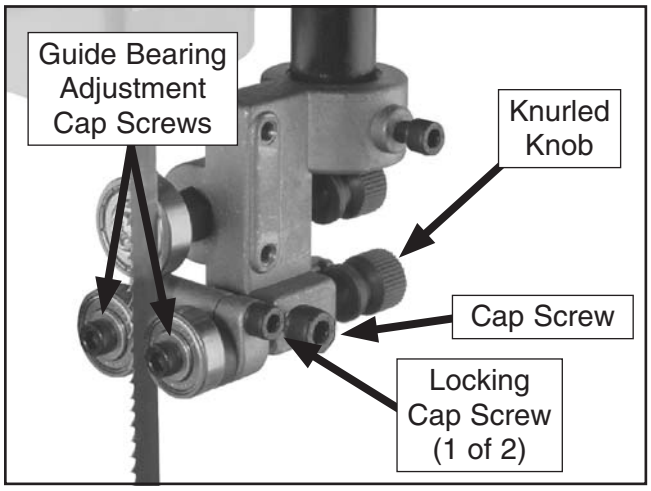


Figure 33. Blade guide bearing controls.

3. Loosen the cap screw shown in the figure above, then use the knurled knob to adjust the guide bearings laterally so the bearing faces are just behind the blade gullet, as illustrated in **Figure 34**, and re-tighten the thumbscrew to secure the setting.

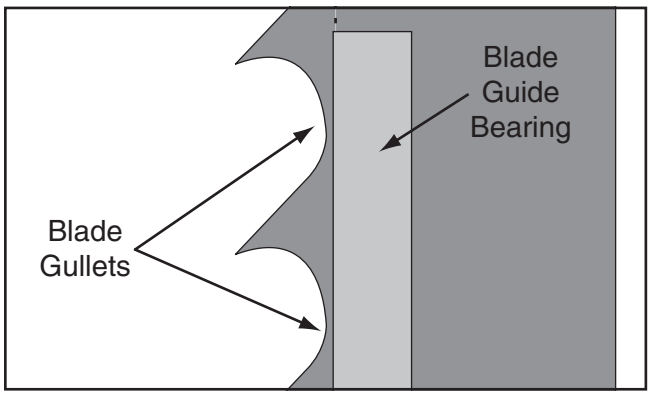


Figure 34. Blade guide bearing positioned just behind the blade gullets.

Note: *With wider blades, it may not be possible to bring the guide bearings just behind the blade gullets. Position them as far forward as possible without allowing the guide bearing housing to touch the back of the blade.*

NOTICE

The set of the teeth increase the chance of the bearings contacting the teeth during a cutting operation as the set of the teeth is wider than the blade. The support bearing must be set to prevent this.

4. Loosen both cap screws behind the guide bearings, then rotate the adjustment cap screws so the bearings evenly and lightly touch the sides of the blade (see the illustration in **Figure 35**) without deflecting it one way or the other.

   Note: *When the blade guide bearings are properly adjusted against the blade, they should rotate smoothly as the blade moves.*

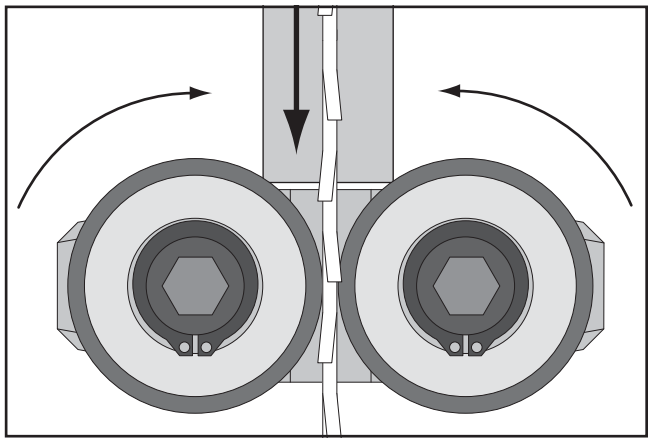


Figure 35. Blade guide bearings evenly and lightly touching the sides of the blade.

5. Using a hex wrench, tighten the locking cap screws to secure the settings. To prevent unwanted movement while tightening, use a hex wrench to hold the adjustment cap screws in place while re-tightening the locking cap screws. Re-check the setting after tightening.

NOTICE

Whenever changing a blade or adjusting the blade tension or tracking, the support and guide bearings must be re-adjusted before resuming operation to ensure proper blade support.

Table Tilt Calibration

When properly adjusted, the positive stop bolt enables the table to be quickly returned perpendicular to the blade.

To tilt the table to the left, the positive stop bolt (see **Figure 36**) must be lowered, then re-adjusted after the table is returned to 0°.

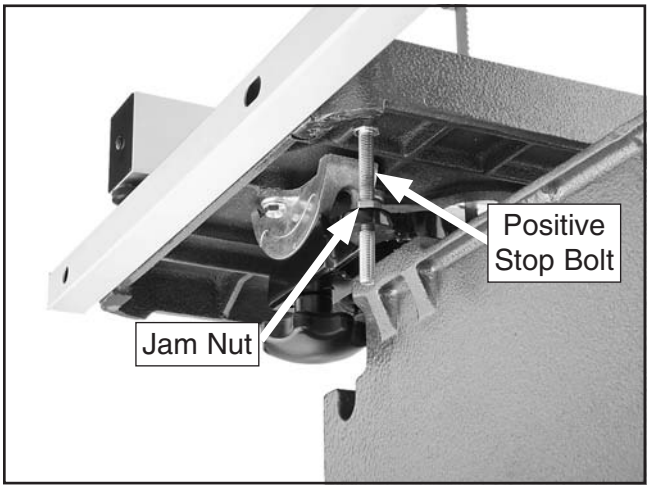


Figure 36. Positive stop bolt set so table is 90° to the blade (viewed from behind the table).

Tools Needed	**Qty**
Wrench 13mm	1
Phillips Screwdriver #2	1
Machinist's Square	1

To set the positive stop so the table is 90˚ to the blade:

1. Make sure the blade is correctly tensioned as described in **Tensioning Blade** on **Page 23**.

2. DISCONNECT BANDSAW FROM POWER!

3. Loosen the two table lock knobs that secure the table to the trunnions.

4. Loosen the jam nut that locks the positive stop bolt in place.

5. Completely raise the upper blade guide assembly, then place the machinist's square flat on the table and against the side of the blade, as illustrated in **Figure 37**.

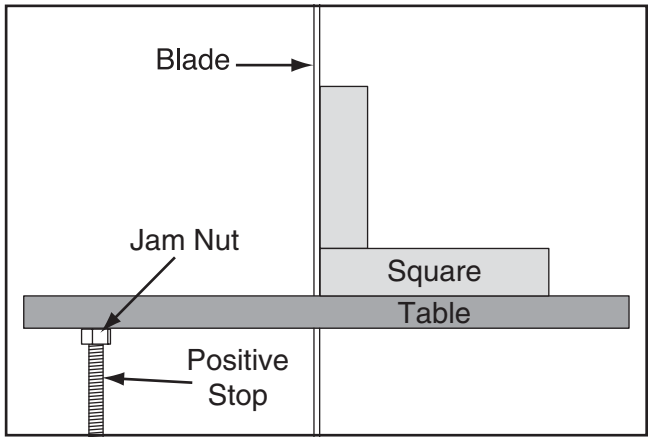


Figure 37. Using a square to adjust the table perpendicular to the side of the blade.

6. Raise or lower the positive stop bolt until the table is perpendicular to the side of the blade, then re-tighten the jam nut (see **Figure 36**) against the casting to secure the setting.

7. Rest the table on the positive stop bolt, then re-tighten the table lock knobs.

8. Observe the position of the table tilt pointer on the tilt scale located underneath the front of the table (see **Figure 38**).

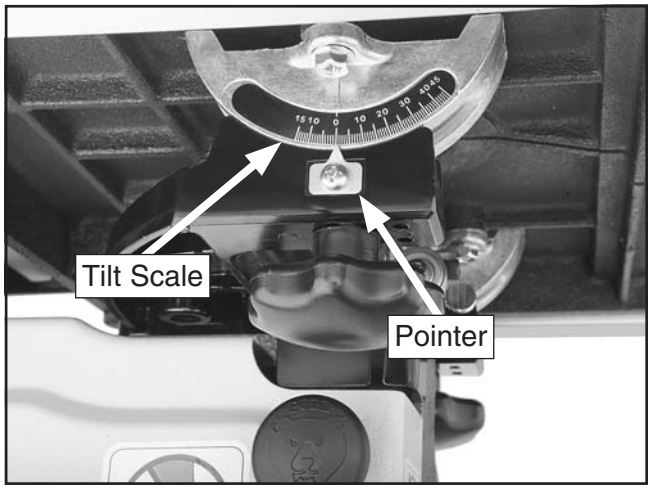


Figure 38. Location of the table tilt scale.

9. Loosen the Phillips head screw securing the pointer, adjust the pointer to 0°, then retighten the Phillips head screw.

Aligning Table

To ensure cutting accuracy, the table must be aligned so the miter slot is parallel with the bandsaw blade.

Tools Needed	Qty
Straightedge 2'	1
Fine Ruler	1
Masking Tape	As Needed
Wrench 10mm	1

To align the table miter slot parallel to the blade:

1. Make sure the blade is correctly tensioned as described in the **Tensioning Blade** subsection earlier in this manual.

2. DISCONNECT BANDSAW FROM POWER!

3. Make sure the table is perpendicular to the side of the blade and is locked in place.

4. Place an accurate straightedge along the blade. The straightedge should lightly touch both the front and back of the blade (see **Figure 39**).

   Note: *Make sure the straightedge does not go across a tooth while performing this step.*

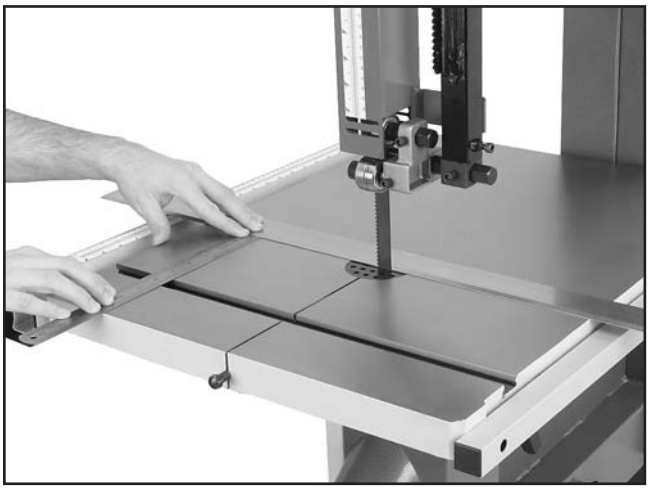


Figure 39. Placing a straightedge along the blade and measuring to the miter slot.

5. Use the fine ruler to measure the distance between the straightedge and miter slot at the front and back of the table (see **Figure 39**).

   —If the distances are the same, no further adjustments are required.

   —If the distances are different, continue with **Step 6**.

6. Loosen the six flange bolts that secure the table to the trunnion brackets (see **Figure 40**).

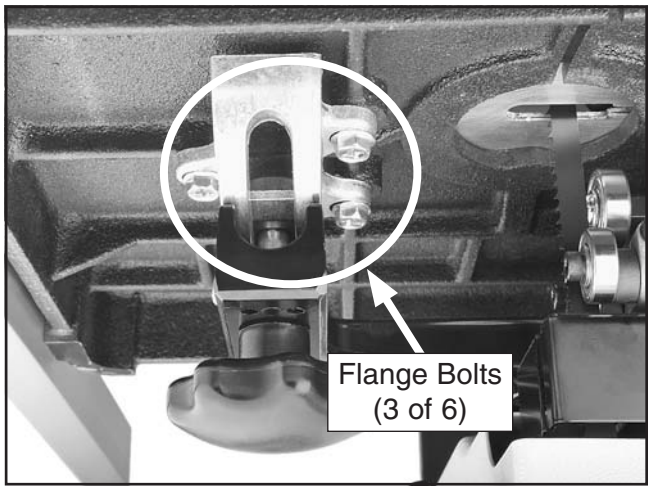


Figure 40. Location of trunnion bracket flange bolts.

7. Position the table so that the distances are equal between the straightedge and miter slot at the front and the back of the table.

8. Taking care not to move the table further, re-tighten the flange bolts.

9. Verify the setting and, if necessary, repeat this procedure until you are satisfied with the adjustment.

Aligning Fence

To ensure accurate cutting when using the fence, the face of the fence must be parallel to the table miter slot and, thus, to the side of the blade.

Tools Needed	**Qty**
Hex Wrench 5mm	1

To align the fence parallel with the miter slot:

1. Make sure the miter slot is parallel with the blade, as instructed in the previous **Aligning Table** procedure.

2. DISCONNECT BANDSAW FROM POWER!

3. Install the fence on the right side of the blade, even with the edge of the miter slot, then lock it in place.

   —If the fence is parallel with the miter slot, no additional adjustment is necessary.

   —If the fence is not parallel with the miter slot, proceed to **Step 4**.

4. Loosen the four fence adjustment cap screws shown in **Figure 41**, adjust the fence parallel to the miter slot, then re-tighten the cap screws to secure the setting.

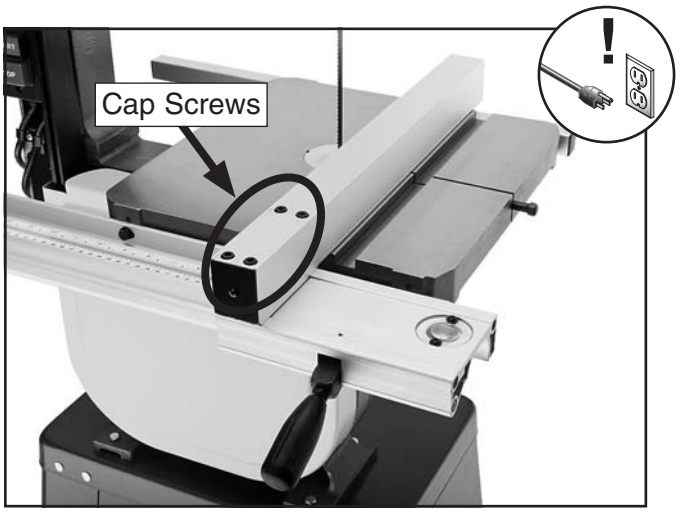


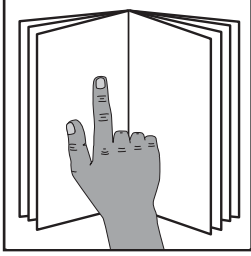
Figure 41. Location of the fence adjustment cap screws.

SECTION 4: OPERATIONS

Operation Overview

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand.

Due to the generic nature of this overview, it is **not** intended to be an instructional guide. To learn more about specific operations, read this entire manual and seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.

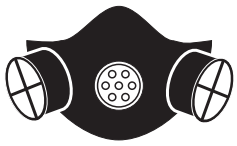


⚠WARNING

To reduce the risk of serious injury when using this machine, read and understand this entire manual before operating.

⚠WARNING

Damage to your eyes and lungs could result from using this machine without proper protective gear. Always wear safety glasses and a respirator when operating this machine.



NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, review industry trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

To complete a typical operation, the operator does the following:

1. Examines the workpiece to make sure it is suitable for cutting.
2. Adjusts the fence for the width of the cut and then locks it in place.
3. Adjusts the table tilt, if necessary, to the correct angle of the desired cut.
4. Loosens the guide post lock knob, adjusts the upper blade guide height to just clear the workpiece (no more than ¼"), then retightens the guide post lock knob.
5. Checks to make sure the workpiece can safely pass all the way through the blade without interference from other objects.
6. Puts on safety glasses and a respirator.
7. Starts the dust collector and bandsaw.
8. Holds the workpiece firmly and flatly against both the table and fence, and then pushes the workpiece into the blade at a steady and controlled rate until the cut is complete.

   The operator is very careful to keep fingers away from the blade and uses a push stick to feed narrow workpieces.
9. Stops the bandsaw.

The bandsaw is one of the most versatile wood cutting tools in the shop. It is capable of performing the following types of cuts:

Straight Cuts

- Miters
- Angles
- Compound Angles
- Resawing
- Ripping
- Crosscutting

Irregular Cuts

- Simple and Complex Curves
- Duplicate Parts
- Circles
- Beveled Curves

A properly adjusted bandsaw can be safer to operate than most other saws and performs many functions with ease and accuracy.

Basic Cutting Tips

Here are some basic tips to follow when operating the bandsaw:

- Replace, sharpen, and clean blades often for best performance. Check guide, tension, and alignment settings periodically and adjust when necessary to keep the saw running in top condition.

- Use light and even pressure while cutting. Light feeding pressure makes it easier to cut straight and prevents undue friction or strain on the bandsaw components.

- Avoid twisting the blade when cutting around tight corners. Allow the blade to saw around the corners. Use relief cuts when possible.

- Misusing the saw or using incorrect techniques (e.g. twisting the workpiece, incorrect feed rate, etc.) is unsafe and results in poor cuts.

Disabling & Locking Switch

The ON/OFF switch can be disabled and locked by inserting a padlock through the ON button, as shown. Locking the switch in this manner can prevent unauthorized operation of the machine, which is especially important if the machine is not stored inside an access-restricted building.

IMPORTANT: Locking the switch with a padlock only restricts its function. It is not a substitute for disconnecting power from the machine when adjusting or servicing.

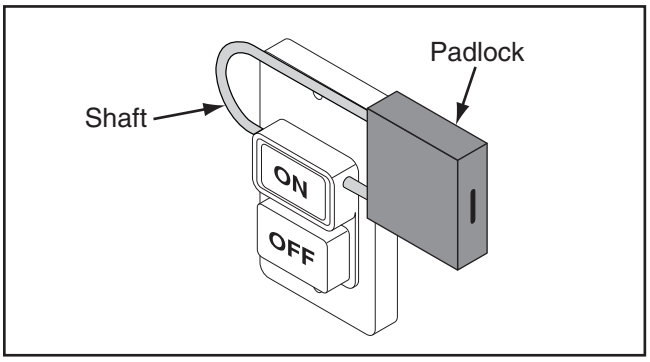


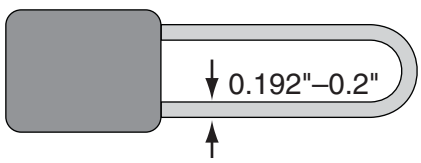
Figure 42. Switch disabled by a padlock.

⚠WARNING

Children or untrained people can be seriously injured by this machine. This risk increases with unsupervised operation. To help prevent unsupervised operation, disable and lock the switch before leaving machine unattended! Place key in a well-hidden or secure location.

NOTICE

The padlock shaft diameter is important to the disabling function of the switch. With any padlock used to lock the switch, test the switch after installation to ensure that it is properly disabled.



Workpiece Inspection

Some workpieces are not safe to cut or may require modification before they are safe to cut. **Before cutting, inspect all workpieces for the following:**

- ***Material Type:*** This machine is intended for cutting natural and man-made wood products, laminate covered wood products, and some plastics. Cutting drywall or cementitious backer board creates extremely fine dust and may reduce the life of the bearings. This machine is NOT designed to cut metal, glass, stone, tile, etc.; cutting these materials with a bandsaw may lead to injury.

- ***Foreign Objects:*** Nails, staples, dirt, rocks and other foreign objects are often embedded in wood. While cutting, these objects can become dislodged and hit the operator and bind or break the blade, which might then fly apart. Always visually inspect your workpiece for these items. If they can't be removed, DO NOT cut the workpiece.

- ***Large/Loose Knots:*** Loose knots can become dislodged during the cutting operation. Large knots can break blade teeth and cause machine damage. Choose workpieces that do not have large/loose knots or plan ahead to avoid cutting through them.

- ***Wet or "Green" Stock:*** Cutting wood with a moisture content over 20% causes unnecessary wear on the blades, increases the risk of kickback, and yields poor results.

- ***Excessive Warping:*** Workpieces with excessive cupping, bowing, or twisting are dangerous to cut because they are unstable and often unpredictable when being cut. DO NOT use workpieces with these characteristics!

- ***Minor Warping:*** Workpieces with slight cupping can be safely supported if the cupped side is facing the table or the fence. A workpiece supported on the bowed side may move unexpectedly resulting in severe injury.

Guide Post

The guide post, shown in **Figure 43**, allows the upper blade guide assembly to be quickly adjusted for height. When cutting, the blade guides must always be positioned so they just clear (no more than ¼") the workpiece.

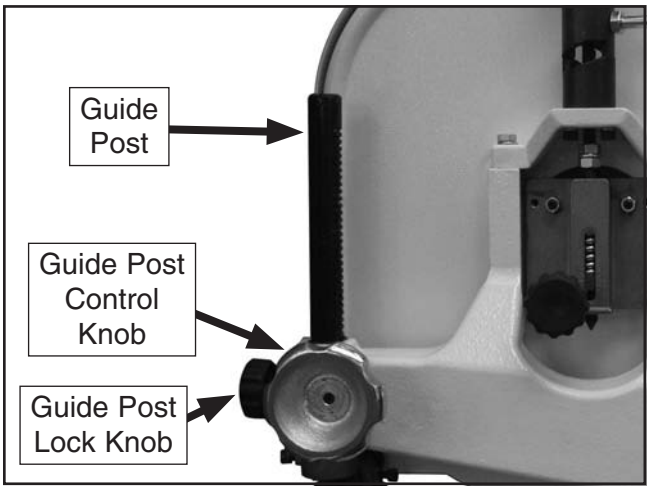


Figure 43. Guide post and lock knob.

To adjust the height of the guide post:

1. Make sure the motor is OFF.

2. Loosen the guide post lock knob.

3. Using the guide post control knob, adjust the height of the guide post so that the blade guide assembly just clears (no more than ¼") the workpiece.

4. Re-tighten the lock knob to secure the setting.

Table Tilt

The table can be tilted to make angled or beveled cuts. A simple tilt scale is provided on the trunnion for a quick gauge (see **Figure 44**). For more accurate results use a protractor.

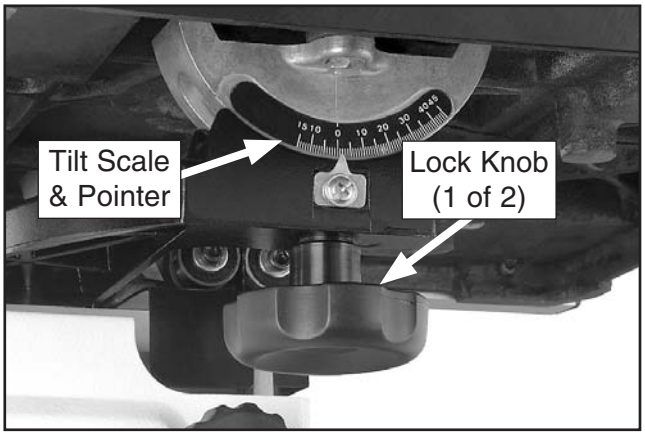


Figure 44. Table tilt controls.

Note: *When tilting the table to the left, the positive stop bolt must be lowered. Be sure to re-adjust it when returning the table to be perpendicular with the blade.*

To tilt the table:

1. DISCONNECT BANDSAW FROM POWER!

2. Loosen both table lock knobs underneath the table.

3. Tilt the table to the desired angle, then re-tighten the lock knobs.

Blade Speed

The Model G0555LX offers blade speeds of 1800 and 3100 FPM. Speed changes are made by repositioning the V-belt in different pulley grooves.

Keep in mind, cutting results are not just related to blade speed. Other factors include: the type of workpiece, the blade being used for the operation, and the feed rate.

Use the chart below as a general guide for which blade speeds to use for various operations:

Type of Cutting Operation	Blade Speed (FPM)
General Woodworking	3100
Super Dense Hardwood	1800
Fast/Average Feed Rate	3100
Requires Slow Feed Rate	1800
Rough Edges Acceptable	3100
Requires Smooth Edges	1800
Quick, Production Cuts	3100
Detailed, Intricate Cuts	1800

Tools Needed **Qty**
Hex Wrench 6mm..... 1

To change the blade speed:

1. DISCONNECT BANDSAW FROM POWER!

2. Open the lower wheel cover, and loosen the motor mount cap screws shown in **Figure 45**.

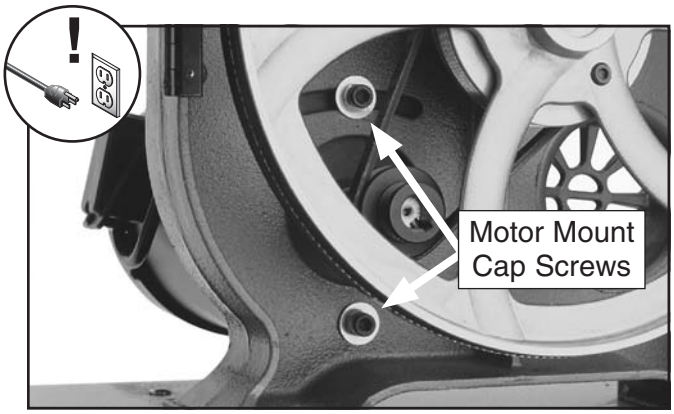


Figure 45. Motor mount cap screws.

3. Pivot the motor so the upper cap screw slides to the right of the slot. This releases the belt tension.

4. Position the belt in the pulley grooves needed (see **Figure 46**) for the desired speed.

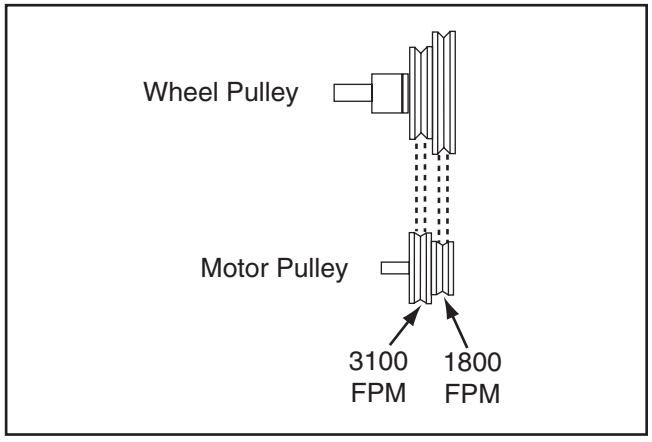


Figure 46. Belt positions for different speeds.

5. Pivot the motor so the upper cap screw slides left in the slot.

6. Apply pressure on the motor so there is approximately ¼" V-belt deflection (see **Figure 47**), then re-tighten the motor mount cap screws.

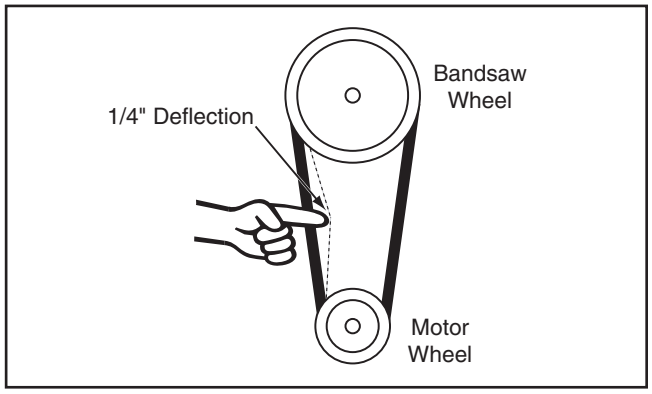


Figure 47. ¼" V-belt deflection.

7. Close the lower wheel cover before re-connecting the bandsaw to power.

Blade Information

Blade Dimensions

Length Range..... 93½"
Width Range..... ⅛"–¾"

Selecting the right blade requires a knowledge of the various blade characteristics to match the blade with the particular cutting operation.

Blade Length

Measured by the circumference, blade lengths are usually unique to the brand of your bandsaw and the distance between wheels. Blades will vary slightly even in the same length because of how they are welded. Refer to the **Accessories** section later in this manual for blade replacements from Grizzly.

Blade Width

Measured from the back of the blade to the tip of the blade tooth (the widest point), blade width is often the first consideration given to blade selection. Blade width dictates the largest and smallest curve that can be cut, as well as how accurately it can cut a straight line.

Always pick the size of blade that best suits your application.

- **Curve Cutting:** Use the chart in **Figure 48** to determine the correct blade for curve cutting. Determine the smallest radius curve that will be cut on your workpiece and use the corresponding blade width.

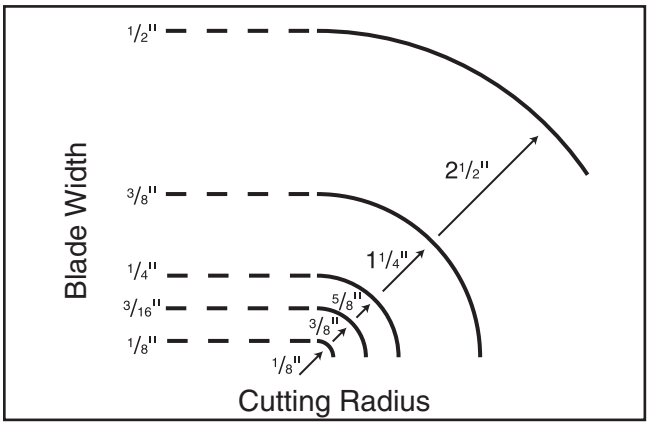


Figure 48. Recommended cutting radius per blade width.

- **Straight Cutting:** Use the largest width blade that you own. Large blades excel at cutting straight lines and are less prone to wander.

Tooth Style

Figure 49 illustrates the three main blade tooth styles:

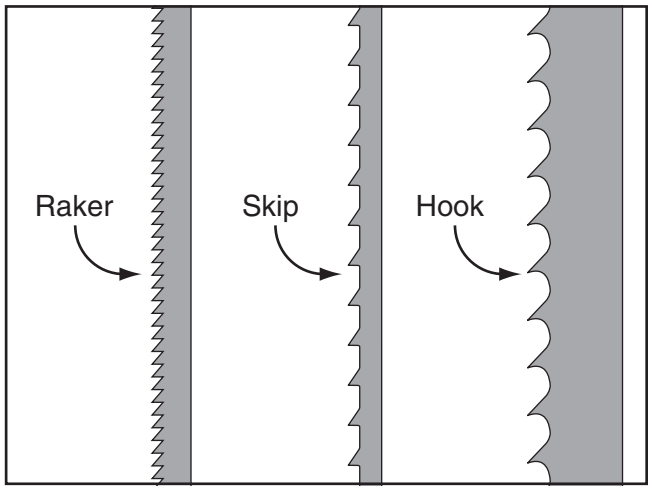


Figure 49. Main blade tooth styles.

- **Raker**: Considered to be the standard because the tooth size and shape are the same as the tooth gullet. The teeth on raker blades usually are very numerous, have no angle, and produce cuts by scraping the material. As a result, smooth cuts can be achieved without cutting fast or generating more heat than other tooth types.

- **Skip**: Similar to a raker blade that is missing every other tooth. Because of the design, skip toothed blades have a much larger gullet than raker blades, and therefore, cut faster and generate less heat. However, these blades also leave a rougher cut than raker blades.

- **Hook**: The teeth have a positive angle (downward) which makes them dig into the material, and the gullets are usually rounded for easier waste removal. These blades are excellent for the tough demands of resawing and ripping thick material.

Tooth Pitch

Measured as TPI (teeth per inch), tooth pitch determines the number of teeth. More teeth per inch (fine pitch) will cut slower, but smoother; while fewer teeth per inch (coarse pitch) will cut rougher, but faster. As a general rule, choose blades that will have at least three teeth in the material at all times. Use fine-pitched blades on harder woods and coarse-pitched blades on softer woods.

Blade Care

A bandsaw blade is a thin piece of steel that is subjected to tremendous stresses when cutting. You can obtain longer use from a bandsaw blade if you give it fair treatment and always use the appropriate feed rate for your operation. Be sure to select blades with the proper width, style, and pitch for each application. The wrong choice of blades will often produce unnecessary heat which will shorten the life of your blade.

A clean blade will perform much better than a dirty blade. Dirty or gummed up blades pass through the cutting material with much more resistance than clean blades. This extra resistance also causes unnecessary heat. Resin/pitch cleaners are excellent for cleaning dirty blades.

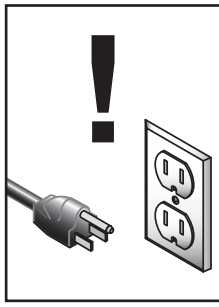
Blade Breakage

Many conditions may cause a bandsaw blade to break. Blade breakage is unavoidable, in some cases, since it is the natural result of the peculiar stresses that bandsaw blades are subjected to. Blade breakage is also due to avoidable circumstances. Avoidable breakage is most often the result of poor care or judgement on the part of the operator when mounting or adjusting the blade or blade guides.

The most common causes of blade breakage are:

- Faulty alignment/adjustment of the guides.
- Forcing/twisting a wide blade around a short radius.
- Feeding the workpiece too fast.
- Dull teeth or damaged tooth set.
- Over-tensioned blade.
- Upper blade guide assembly set too high above the workpiece.
- Using a blade with a lumpy or improperly finished braze or weld.
- Continuously running the bandsaw when not in use.
- Leaving blade tensioned when not in use.
- Using the wrong TPI for the workpiece thickness. (The general rule of thumb is three teeth in the workpiece at all times.)

Changing Blade



⚠WARNING

Disconnect bandsaw from power BEFORE changing blade. Serious personal injury could occur if machine is started during this procedure.

⚠CAUTION

LACERATION HAZARD! Bandsaw blades are sharp and difficult to handle. Wear heavy leather gloves while handling to reduce the risk of being cut.

1. DISCONNECT BANDSAW FROM POWER!

2. Move the blade tension quick release lever to the left to release blade tension.

3. Adjust the upper blade guide assembly all the way up, and move the blade guides completely away from the blade.

4. Remove the fence and miter gauge from the table, then remove the table insert and table pin (see **Figure 50**).

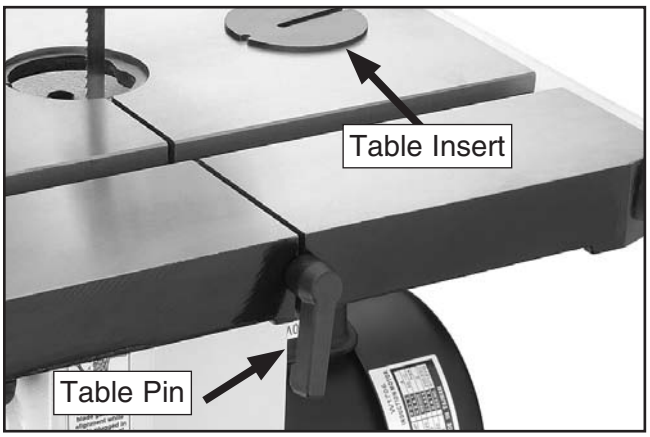


Figure 50. Table insert and table pin.

5. Open the upper and lower wheel covers.

6. Put on heavy leather gloves.

7. Slip the blade off the wheels, rotate it 90°, and slide it through the table slot and off the machine.

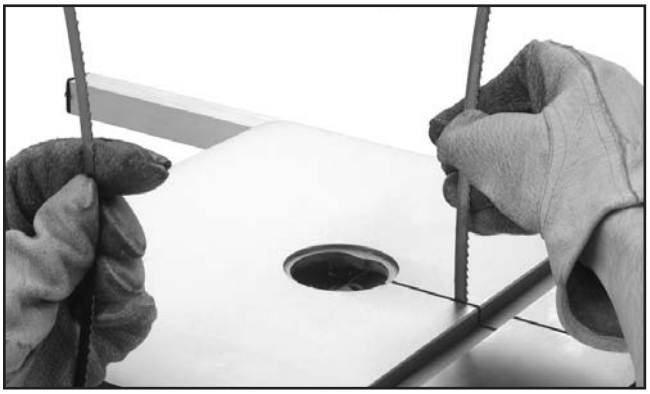


Figure 51. Changing the blade.

8. Position the blade so that the teeth are facing to the right and down toward the table, then slide it through the table slot.

   Note: *If the teeth will not point downward in any orientation, the blade is inside out. Remove the blade and twist it right-side out.*

9. Rotate the blade 90°, then slip it over the wheels while making sure it is properly positioned between the blade guards and guides.

10. Move the blade tension quick release lever to the right, for rough tensioning the blade. Using the blade tension adjustment knob and tension scale, fine tune the tension for the new blade.

    —If you successfully move the quick release lever to the right and the blade is properly tensioned, continue with **Step 6**.

    —If you have difficulty moving the blade tension quick release lever to the right or the blade is a different length from the previous blade, adjust the blade tensioner, as instructed in the **Blade Tensioner** on **Page 52**, then continue with **Step 6**.

11. Adjust the blade tracking (see **Blade Center Tracking** on **Page 19**).

12. Adjust the support bearings and the upper/lower blade guides (see **Adjusting Blade Support Bearings** on **Page 25**).

13. Close the wheel covers, and replace the table insert and table pin.

Ripping

"Ripping" means cutting with the grain of the wood stock. For plywood and other processed wood, ripping simply means cutting down the length of the workpiece. Beveled rip cuts may be performed by tilting the table.

To make a rip cut:

1. Adjust the fence to match the width of the cut on your workpiece, then lock the fence in place.

2. Adjust the blade guide assembly to the proper height above the workpiece.

3. After all safety precautions have been met, turn the bandsaw ***ON*** and wait for it to come to full speed. Slowly feed the workpiece into the blade until the blade is completely through the workpiece. **Figure 52** shows an example of a ripping operation.

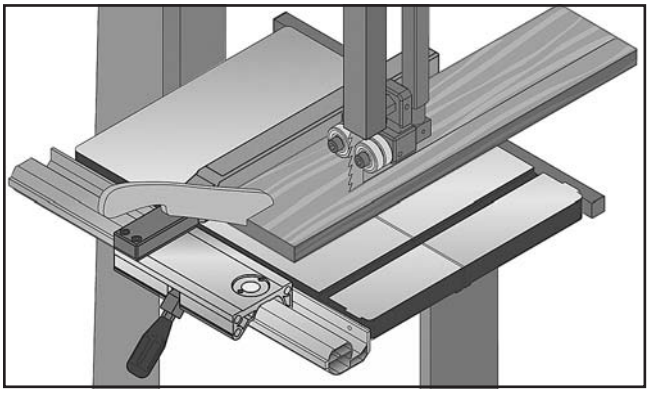


Figure 52. Example of a ripping operation.

⚠WARNING

ALWAYS use a push stick when ripping narrow pieces. Failure to follow these warnings may result in amputation or laceration injuries!

⚠WARNING

NEVER place fingers or hands in the line of cut. If you slip, your hands or fingers may go into the blade and may be cut.

Crosscutting

Crosscutting is the process of cutting across the grain of wood. For plywood and other processed wood, crosscutting simply means cutting across the width of the material. Crosscuts can be 90° or angled using the miter gauge. Compound crosscuts are those where the miter is angled and the table titled.

To make a crosscut:

1. Mark the workpiece on the edge where you want to begin the cut.

2. Adjust the blade guide assembly to the correct height.

3. Adjust the miter gauge to the correct angle needed for the cut.

4. Move the fence out of the way. Place the workpiece evenly against the miter gauge, then line up the mark with the blade.

5. After all safety precautions have been met, turn the bandsaw ***ON*** and wait for it to come to full speed. Slowly feed the workpiece into the blade until the blade is all the way through the workpiece. **Figure 53** shows an example of a crosscutting operation.

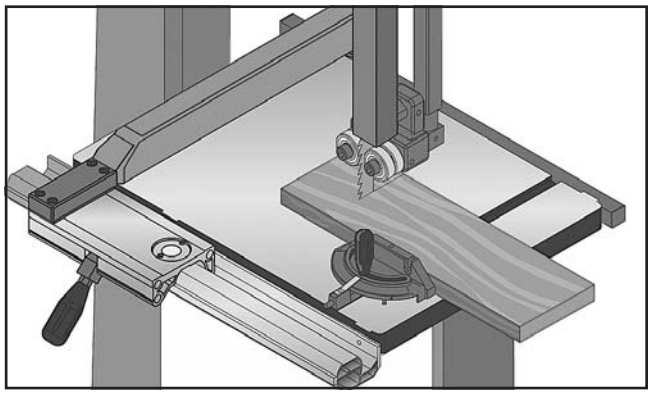


Figure 53. Example of a crosscutting operation with the miter gauge.

Resawing

"Resawing" means cutting the thickness of a board into two or more thinner boards (see **Figure 54** for an example). The maximum height of a board that can be resawn is limited by the maximum cutting height of the bandsaw.

One of the most important considerations for resawing is blade selection—a wide blade cuts straighter and is less prone to blade lead (see the **Blade Lead** subsection later in this manual for more information).

For most applications, use a blade with a hook or a skip tooth style. Choose blades with fewer teeth-per-inch (from 3 to 6 TPI), because they offer larger gullet capacities for clearing sawdust, which reduces heat buildup and strain on the motor.

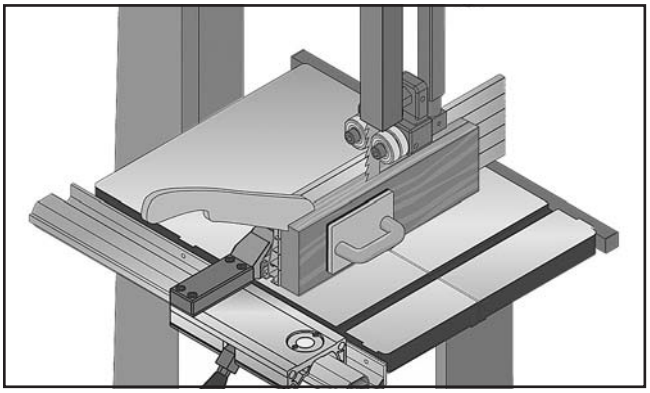


Figure 54. Example of a resawing operation.

⚠WARNING

When resawing thin pieces, a wandering blade (blade lead) can tear through the side of the workpiece, exposing your hands to the blade teeth. Always use push blocks when resawing and keep your hands clear of the blade.

Cutting Curves

When cutting curves, simultaneously feed and turn the stock carefully so the blade follows the layout line without twisting. If curves are sharp or tight, use a narrower blade with more TPI (teeth per inch) and make relief cuts to avoid having to back the workpiece away from the blade.

Always make short cuts first, then proceed to the longer cuts. Relief cuts reduce the chance of the blade being pinched or twisted. Relief cuts are cuts made through the waste portion of the workpiece and are stopped at the layout line, so when you're cutting along the layout line, waste wood is released from the workpiece, alleviating any pressure on the back of the blade. Relief cuts also make it easier to back the workpiece out once the saw blade has come to a stop, if needed.

NOTICE

The list below displays blade widths and the corresponding minimum radii for those blade widths.

Width	Min. Radius
1/8"	1/8"
3/16"	3/8"
1/4"	5/8"
3/8"	1 1/4"
1/2"	2 1/2"
5/8"	3 3/4"
3/4"	5 1/2"

Stacked Cuts

One of the benefits of a bandsaw is its ability to cut multiple copies of a particular shape by stacking a number of workpieces together. However, before making stacked cuts, ensure that the table is perpendicular (90°) to the blade—otherwise, any error in this setting will be compounded in the workpieces.

To complete a stacked cut:

1. Align the workpieces from top to bottom.

2. Secure all the pieces together in a manner that will not interfere with the cutting. Hot glue on the edges works well, as do brad nails through the waste portion. (Be careful not to cut into the brads or you may break the blade!)

3. On the face of the top piece, lay out the shape you intend to cut.

4. Make relief cuts perpendicular to the outline of your intended shape in areas where changes in blade direction could strain the woodgrain or cause the blade to bind.

5. Cut the stack of pieces as though you were cutting a single piece. Follow your layout line with the blade kerf on the waste side of your line (see **Figure 55** for an example of a stacked cut setup).

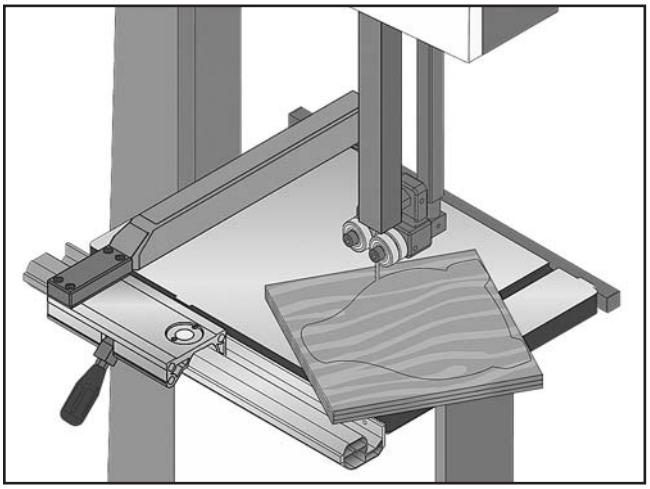


Figure 55. Example of a stacked cut setup.

SECTION 5: ACCESSORIES

⚠WARNING

Some aftermarket accessories can be installed on this machine that could cause it to function improperly, increasing the risk of serious personal injury. To minimize this risk, only install accessories recommended for this machine by Grizzly.

NOTICE

Refer to the newest copy of the Grizzly Catalog for other accessories available for this machine.

Call 1-800-523-4777 To Order

Grizzly Bandsaw Blades

MODEL	LENGTH	WIDTH	TPI	GAUGE
G5151	93½"	1/16"	24 Raker	0.025
G5152	93½"	1/8"	14 Raker	0.025
G5153	93½"	1/8"	18 Raker	0.025
G5154	93½"	3/16"	4 Skip	0.025
G5155	93½"	3/16"	10 Raker	0.025
G5156	93½"	3/16"	14 Raker	0.025
G5157	93½"	1/4"	4 Hook	0.025
G5158	93½"	1/4"	6 Hook	0.025
G5159	93½"	1/4"	10 Raker	0.025
G5160	93½"	1/4"	14 Raker	0.025
G5161	93½"	1/4"	18 Raker	0.025
G5162	93½"	3/8"	4 Hook	0.025
G5163	93½"	3/8"	6 Hook	0.025
G5164	93½"	3/8"	10 Raker	0.025
G5165	93½"	3/8"	14 Raker	0.025
G5166	93½"	1/2"	3 Hook	0.025
G5167	93½"	1/2"	4 Hook	0.025
G5168	93½"	1/2"	6 Hook	0.025
G5169	93½"	1/2"	10 Raker	0.025
G5170	93½"	1/2"	14 Raker	0.025
G5171	93½"	3/4"	3 Hook	0.025
G5172	93½"	3/4"	6 Hook	0.025
G5173	93½"	3/4"	10 Raker	0.025

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T20388—Success With Bandsaws
Explore the many creative possibilities of floor-standing and portable bench-top bandsaws. With these practical instructions and color photographs, woodworkers can quickly master basic skills and then practice advanced procedures like making dovetail, mortise and tenon joints and cutting variable-curve edges— even make their own money-saving jigs and templates. 176 pages.

Figure 56. Success with Bandsaws book.

T25555—6" Extension Block Kit
Increase your cutting capacity from 6" to 12" cutting height with this bolt-on 6" extension block kit. Includes all necessary hardware plus extended blade guard and 105" x 3/8" x 6 TPI blade. *We also carry a full line of 105" blades!*

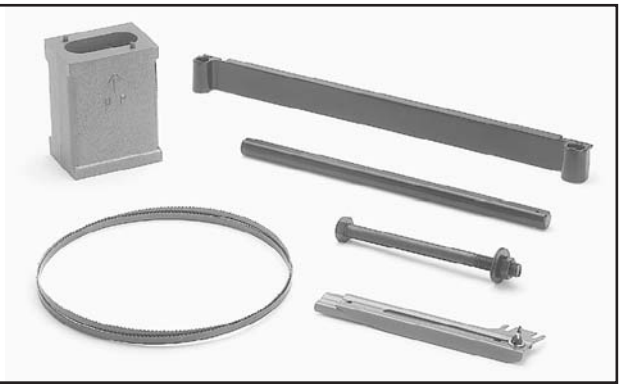

Figure 57. T25555 Extension Block Kit.

Timberwolf® 93½" Bandsaw Blades

Timber Wolf® Band Mill Blades are high performance bands. The exclusive use of low tensioned, high ductile Swedish silicon steel, unique geometric gullet designs and sets, unique manufacturing processes and quality control has resulted in the production of the finest band saw blades in the world. High Performance (HP) and Raker (RK) blades are specifically designed for detail work in 1" and smaller kiln dried wood when a very clean finish is required. They are also effective in plywood and other woods where tear-out is a concern as well as the cutting of soft metals. Positive Claw (PC) blades are everything a wood cutting blade was meant to be. They have over 60% of the speed capabilities of a hook style blade with "hook" style gullet geometry and fast chip removal, while giving you the great finish of a skip. Alternate set (AS-S) blades are only .025" thick with a total overall set is only .048 thousandths of an inch. These bands were specifically designed for straight-line resawing in very expensive, thick woods. These blades utilize the thinnest kerf possible and provide a super finish when speed is not a concern. You cannot go wrong with these blades.

MODEL	LENGTH	WIDTH	TPI	GAUGE
H8507	93½"	⅛"	14 HP	0.025
H8508	93½"	3⁄16"	10 RK	0.025
H8509	93½"	¼"	4 PC	0.025
H8510	93½"	¼"	6 PC	0.025
H8511	93½"	¼"	10 RK	0.025
H8512	93½"	¼"	12 RK	0.025
H8514	93½"	⅜"	3 PC	0.025
H8515	93½"	⅜"	4 PC	0.025
H8516	93½"	⅜"	6 PC	0.025
H8517	93½"	⅜"	10 RK	0.025
H8518	93½"	⅜"	14 RK	0.025
H8519	93½"	½"	3 PC	0.025
H8520	93½"	½"	4 PC	0.025
H8521	93½"	½"	6 PC	0.025
H8522	93½"	½"	10 RK	0.025
H8523	93½"	½"	14 RK	0.025
H8524	93½"	½"	18 RK	0.025
H8525	93½"	¾"	3 AS-S	0.025
H8526	93½"	¾"	6 PC	0.032
H8527	93½"	¾"	10 RK	0.032

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G1163—1HP Floor Model Dust Collector
G1163P—1HP Floor Model Dust Collector
G0710—1HP Wall-Mount Dust Collector
G0710P—1HP Wall-Mount Dust Collector
G3591—30 Micron Replacement Bag
H4340—3.0 Micron Upgrade Bag

Excellent point-of-use dust collectors that can be used next to the machine with only a small amount of ducting. Specifications: 450 CFM, 7.2" static pressure, 2 cubic foot bag, and 30 micron filter. Motor is 1HP, 110V/220V, 14A/7A.

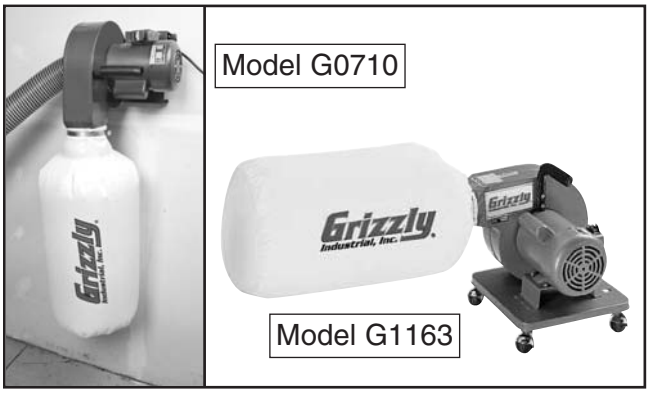

Figure 58. Point-of-use dust collectors.

H7587—Re-Saw Fence Retrofit Kit

This retrofit kit allows you to upgrade your existing aluminum fence for the G0555LX bandsaw to a cast-iron fence with the 6" high re-saw fence. Simply unbolt your existing aluminum fence (4 bolts) and bolt on the new fence kit. Takes less than 10 minutes to switch over.

Figure 59. H7587 Re-Saw Fence Retrofit Kit for the G0555LX Bandsaw.

T23376—Universal Mobile Base
Just add your own piece of plywood to complete this mobile kit for a custom fit under nearly any size machine. Two kickstand-mounted swivel casters easily drop down with a press from the foot for a quick transition from a stationary base to full maneuverability.

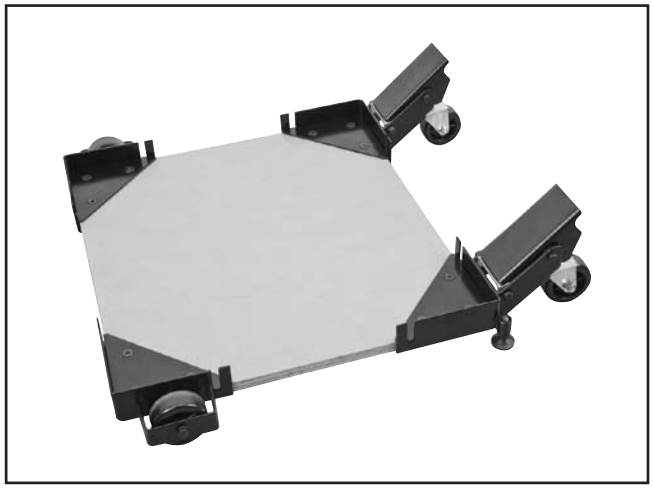

Figure 60. T23376 **SHOP FOX**® Mobile Base.

Basic Eye Protection

T20501—Face Shield Crown Protector 4"
T20502—Face Shield Crown Protector 7"
T20503—Face Shield Window
T20452—"Kirova" Anti-Reflective S. Glasses
T20451—"Kirova" Clear Safety Glasses
H0736—Shop Fox® Safety Glasses
H7194—Bifocal Safety Glasses 1.5
H7195—Bifocal Safety Glasses 2.0
H7196—Bifocal Safety Glasses 2.5

Figure 61. Assortment of basic eye protection.

G8984—Single Roller Stand
G8985—5 Roller Stand
These roller stands are invaluable when working solo in any shop for outfeeding and support tasks. With 15⅞" wide rollers, adjustable 26"–44⅝" height, and all steel construction make them convenient and rugged.

Figure 62. G8984 and G8985 single and 5 roller stands.

G5562—SLIPIT® 1 Qt. Gel
G5563—SLIPIT® 12 oz Spray
G2871—Boeshield® T-9 12 oz Spray
G2870—Boeshield® T-9 4 oz Spray
H3788—G96® Gun Treatment 12 oz Spray
H3789—G96® Gun Treatment 4.5 oz Spray

Figure 63. Recommended lubricants for protecting unpainted cast iron/steel part on machinery.

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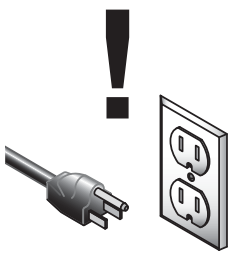
SECTION 6: MAINTENANCE



⚠WARNING

Always disconnect power to the machine before performing maintenance. Failure to do this may result in serious personal injury.

Schedule

For optimum performance from your machine, follow this maintenance schedule:

Daily

- Check/correct loose mounting bolts.
- Check/correct damaged saw blade.
- Check/correct worn or damaged wires.
- Correct any other unsafe condition.

Monthly

- Check for V-belt tension, damage, or wear.
- Remove blade and thoroughly clean all built-up sawdust from the rubber tires on the wheels.
- Clean/vacuum dust buildup from inside cabinet and off motor.

Cleaning

Vacuum excess wood chips and sawdust, and wipe off the remaining dust with a dry cloth. If resin has built up, use a resin dissolving cleaner to remove it.

Once a month, remove the blade and thoroughly clean all built-up sawdust from the rubber tires on the wheels.

Lubricating

Protect the unpainted cast iron surfaces on the table by wiping the table clean after every use—this ensures moisture from wood dust does not remain on bare metal surfaces. Keep tables rust-free with regular applications of products like G96® Gun Treatment, SLIPIT®, Boeshield® T-9 on **Page 40**.

If the table becomes difficult to tilt, remove it and lubricate the trunnions and the slides in the trunnion base.

Redressing Rubber Tires

As the bandsaw ages, the rubber tires on the wheels may need to be redressed if they harden or glaze over. Redressing the rubber tires improves blade tracking and reduces vibration/blade lead.

If the rubber tires become too worn, then blade tracking will become extremely difficult because wheel crown will lose their proper shape. At that point, redressing will no longer be effective and the rubber tires must be replaced.

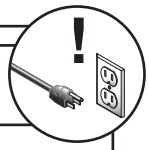
To redress the rubber tires:

1. DISCONNECT BANDSAW FROM POWER!
2. Put on heavy leather gloves.
3. Remove the blade.
4. Clean any built-up sawdust from the rubber tires.
5. Hold 100 grit sandpaper against the rubber tire and rotate the wheel by hand. Only redress the rubber enough to expose a fresh rubber surface.

SECTION 7: SERVICE

Review the troubleshooting and procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support at (570) 546-9663.
Note: *Please gather the serial number and manufacture date of your machine before calling.*

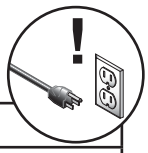
Troubleshooting



Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	1. Power supply is at fault/switched OFF.	1. Ensure hot lines have correct voltage on all legs and main power supply is switched ***ON***.
	2. Plug/receptacle is at fault or wired incorrectly.	2. Test for good contacts; correct the wiring.
	3. Wiring is open/has high resistance.	3. Check for broken wires or disconnected/ corroded connections, and repair/replace as necessary.
	4. Motor connection wired incorrectly.	4. Correct motor wiring connections (**Page 53**).
	5. Start capacitor is at fault.	5. Test/replace.
	6. Motor ON/OFF switch is at fault.	6. Replace faulty ON/OFF switch.
	7. Centrifugal switch is at fault.	7. Adjust/replace centrifugal switch.
Machine stalls or is underpowered.	1. Incorrect workpiece material.	1. Use wood with correct moisture content (20% or less), without glues, and little pitch/resin.
	2. Feed rate too fast for task.	2. Decrease feed rate.
	3. V-belt slipping.	3. Tighten/repair/replace (**Pages 46** and **47**).
	4. Motor connection is wired incorrectly.	4. Correct motor wiring connections (**Page 53**).
	5. Plug/receptacle is at fault.	5. Test for good contacts; correct the wiring.
	6. Motor bearings are at fault.	6. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.
	7. Motor has overheated.	7. Clean off motor, let cool, and reduce workload.
	8. Motor is at fault.	8. Test/repair/replace.
	9. Centrifugal switch is at fault.	9. Adjust/replace centrifugal switch.
Machine has vibration or noisy operation.	1. Motor or component is loose.	1. Inspect/replace stripped or damaged bolts/ nuts, use thread locking fluid, and retighten.
	2. V-belt worn or loose.	2. Tension V-belt (**Page 46**) or replace V-belt (**Page 47**).
	3. Motor fan is rubbing on fan cover.	3. Replace dented fan cover; replace damaged fan.
	4. Pulley is loose.	4. Tighten pulley set screw.
	5. Machine is incorrectly mounted or sits unevenly on floor.	5. Adjust stand feet.
	6. Blade is at fault.	6. Replace blade.
	7. Cast iron motor mount loose/broken.	7. Tighten/replace.
	8. Centrifugal switch is at fault.	8. Adjust/replace centrifugal switch..
	9. Motor or spindle bearings are at fault.	9. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.

Cutting Operations



Symptom	Possible Cause	Possible Solution
Machine slows when operating.	1. Feeding workpiece too fast. 2. Blade is dull. 3. Workpiece moisture content is too high. 4. Incorrect workpiece type.	1. Reduce feed rate. 2. Replace blade (**Page 36**). 3. Replace workpiece. 4. Replace workpiece.
Ticking sound when the saw is running.	1. Blade weld contacting guide/support bearings (a light tick is normal). 2. Blade weld may be failing.	1. Use file or stone to smooth and round the back of the blade; slightly loosen the blade guides. 2. Inspect and replace blade if necessary (**Page 36**).
Blade contacting table insert.	1. Table insert installed upside down or backwards. 2. Table improperly mounted or aligned.	1. Re-install table insert a different way. 2. Align table (**Page 28**).
Vibration when cutting.	1. Loose or damaged blade. 2. Sawdust buildup on wheels.	1. Tighten or replace blade (**Page 36**). 2. Clean all sawdust from rubber tires on wheels.
Burn marks on the edge of the cut.	1. Too much side pressure when feeding workpiece; blade is binding. 2. Blade too wide for size of radius being cut.	1. Feed workpiece straight into the blade. 2. Install a smaller width blade/increase blade tension (**Page 34**).
Rough or poor quality cuts.	1. Feeding workpiece too fast. 2. Blade guides adjusted incorrectly. 3. Incorrect blade selection.	1. Reduce feed rate. 2. Re-adjust all blade support and guide bearings (**Pages 25** and **26**). 3. Choose a the correct blade type for the operation.
Sawdust buildup inside wheel covers.	1. Clogged dust port. 2. Low CFM (airflow) from dust collection system.	1. Clean out dust port. 2. Four options: —Check dust lines for leaks or clogs. —Move dust collector closer to saw. —Install a more powerful dust collector. —Use blast gates to isolate the ducting between the bandsaw and dust collector.

Miscellaneous

Symptom	Possible Cause	Possible Solution
Tensioner mechanism has poor range of motion.	1. Spacer blocks on quick-release tension mechanism have moved out of adjustment.	1. Reset the blade tensioner (**Page 52**).
Blade tension scale is grossly inaccurate.	1. The spring in the blade tension mechanism has lost its "spring." This is caused by not releasing the blade tension when not in use or frequently over-tensioning the bandsaw.	1. Replace spring in the blade tension mechanism, then take better care of the bandsaw by releasing tension when not in use and not over-tensioning the blade.
Wheel is noisy.	1. Wheel bearing is worn out. 2. V-belt is too tight (lower wheel).	1. Replace the wheel bearing. 2. Check/loosen the belt tension (**Page 46**).
Blade does not track	1. Wheels are not coplanar or aligned with each other. 2. Rubber tires on wheels are worn out.	1. Adjust wheels to be coplanar/aligned with each other (**Page 48**). 2. Redress the rubber tires on the wheels (**Page 43**); replace the rubber tires on the wheels.

V-Belt Tension

To ensure optimum power transmission from the motor to the blade, the V-belt must be in good condition and operate under proper tension.

V-belt tension should be checked at least every month—more often if the bandsaw is used daily. If the belt shows signs of cracks, fraying, and excessive wear, replace it as instructed in **Replacing V-Belt** on **Page 47**.

Checking V-Belt Tension

1. DISCONNECT BANDSAW FROM POWER!

2. Open the lower wheel cover.

3. Check V-Belt deflection. The V-belt is properly tensioned if there is approximately ¼" deflection. Deflection is checked by pushing the V-belt with moderate pressure, as shown in **Figure 64**, and noting how much it moves.

   —If the V-belt is not properly tensioned, perform the following **Tensioning V-Belt** procedure.

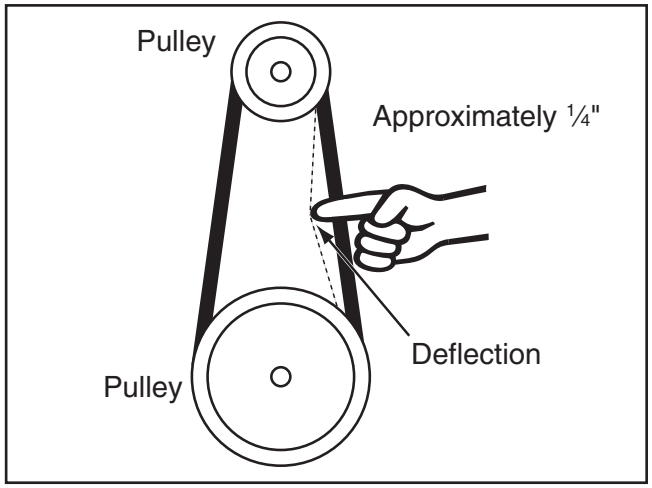


Figure 64. Checking the V-belt tension.

Tensioning V-Belt

Tool Needed	Qty
Hex Wrench 6mm	1

To properly tension the V-belt:

1. DISCONNECT BANDSAW FROM POWER!

2. Open the lower wheel cover, and loosen the motor adjustment and hinge cap screws shown in **Figure 65**.

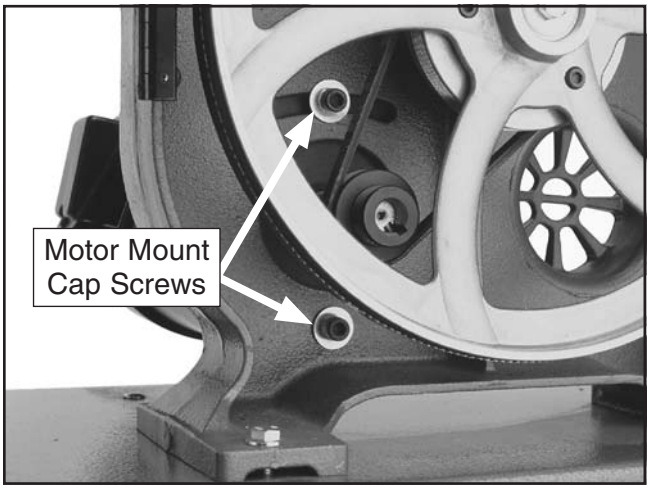


Figure 65. Locations of the motor adjustment and hinge cap screws.

3. Push the motor to the left (as viewed from the front of the machine) until there is approximately ¼" deflection in the V-belt.

4. Re-tighten both cap screws and close the wheel cover.

Replacing V-Belt

To ensure optimum power transmission from the motor to the blade, the V-belt must be in good condition and be properly tensioned.

Replace the V-belt if it shows signs of cracking, fraying, and excessive wear.

Tools Needed	Qty
Hex Wrench 6mm	1
Wrench or Socket 13mm	1
Replacement V-Belt (Part No. P0555LX068)	1

To replace the V-belt:

1. DISCONNECT BANDSAW FROM POWER!

2. Put on heavy leather gloves and remove the blade from the machine.

3. Loosen the motor mount cap screws shown in **Figure 66**.

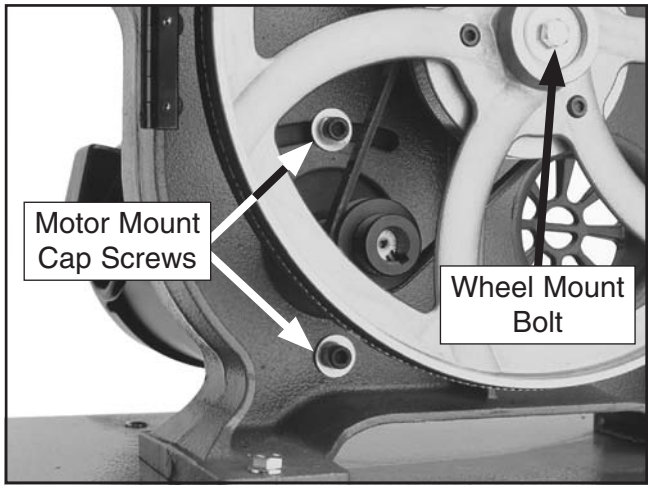


Figure 66. Locations of the wheel mount bolt, and motor mount cap screws.

4. Pivot the motor to the right (as viewed from the front of the bandsaw) so the upper cap screw slides to the right in the slot—this will release the V-belt tension.

5. Roll the V-belt off the pulleys.

6. Remove the wheel mount (it has left hand threads, so it loosens by turning clockwise).

7. Remove the wheel from the shaft. Make sure not to misplace the shaft key.
8. Put new belt on.

9. Align the wheel keyway with the shaft key, and slide the wheel back onto the shaft.

10. Secure the wheel with the wheel mount bolt and flat washer.

11. Position the V-belt on the desired pulleys, then properly tension it, as instructed in **V-Belt Tension** on **Page 46**.

12. Replace the blade, then properly track and tension it (see **Pages 19** and **23**) and adjust the guide and support bearings.

Shimming Table

To ensure accuracy when cutting stacked cuts or circles, the table must be 90° to the back of the blade, as shown in **Figure 67**.

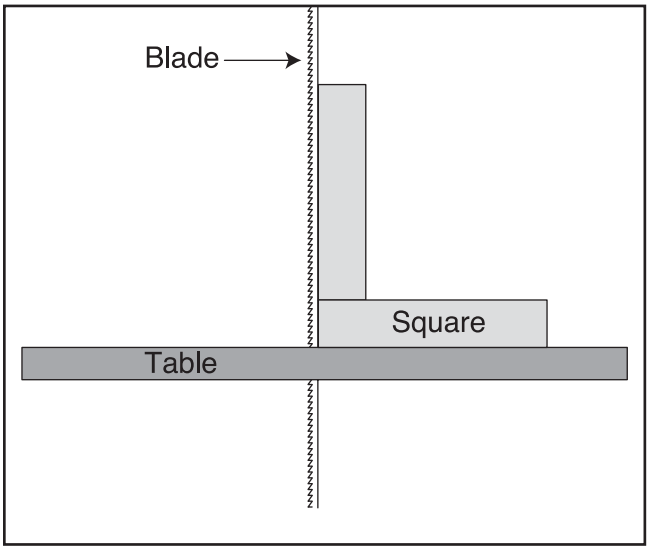


Figure 67. Checking the table to be perpendicular to the back of the blade.

If the table is not perpendicular to the back of the blade, correct this condition by placing shims between the table and trunnions underneath it.

Follow the procedures in **Aligning Table** on **Page 28** to ensure accurate cutting.

Wheel Alignment

Wheel alignment is important for optimal performance from your bandsaw. Wheels are properly aligned when they are parallel with each other and in the same plane or "coplanar" (see the illustration in the figure to the right).

When wheels are coplanar, the bandsaw is more likely to cut straight without wandering; and vibration, heat, and blade wear are considerably decreased because the blade is automatically balanced on the wheel.

Bringing the wheel into alignment may require a combination of shimming a wheel and center/lateral tracking the blade.

Tools Needed	**Qty**
Straightedge 4 ft.	1
Fine Ruler	1
Wrench or Socket 13mm	1
Wrench or Socket 19mm	1

Checking Wheel Alignment

1. DISCONNECT BANDSAW FROM POWER!

2. Remove the table.

3. With the blade on and properly tensioned, hold a straightedge close to the center of both wheels. Make sure the straightedge fully extends across the rims of both wheels, as shown in **Figure 68**.

4. Referring to **Figure 69**, check wheel alignment.

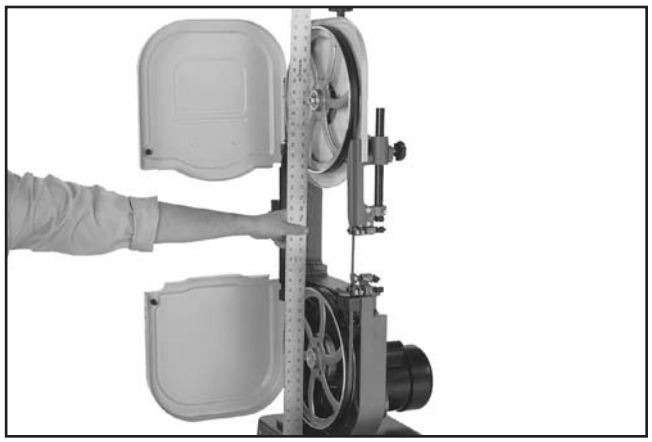


Figure 68. Checking if the wheels are coplanar.

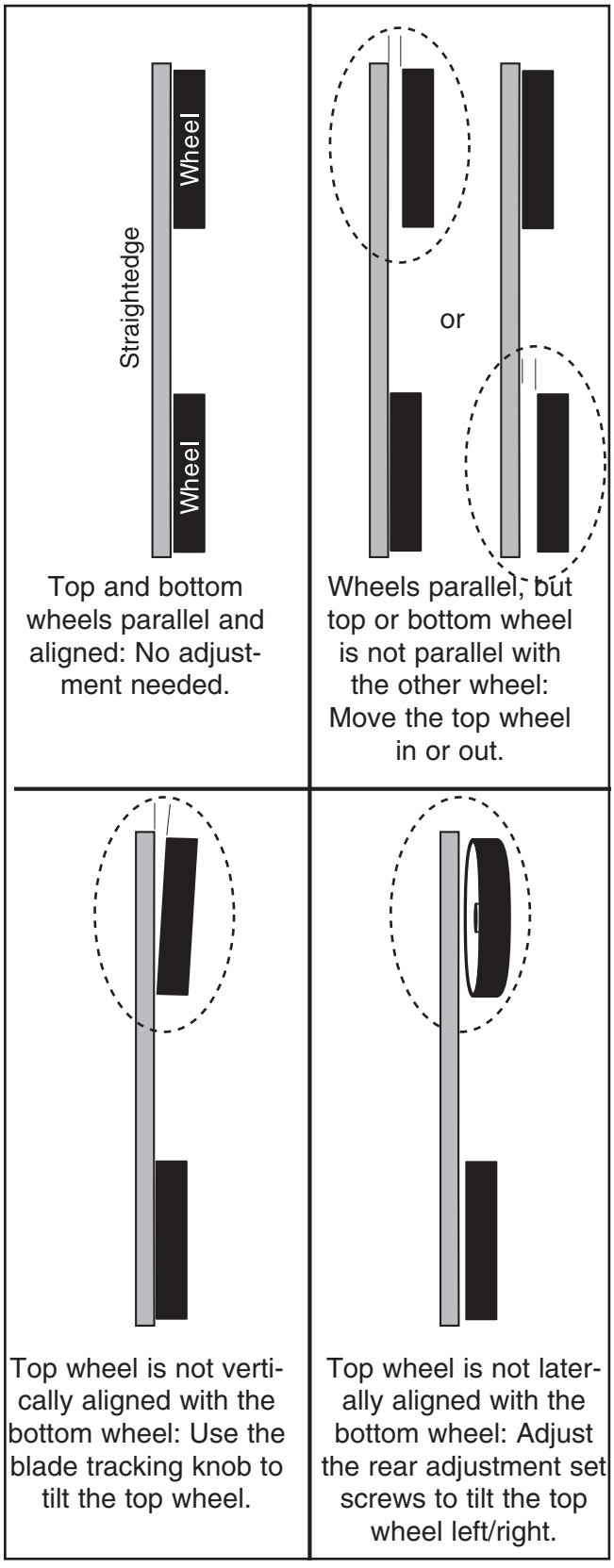

Straightedge
Wheel
Wheel
or
Top and bottom wheels parallel and aligned: No adjustment needed.
Wheels parallel, but top or bottom wheel is not parallel with the other wheel: Move the top wheel in or out.
Top wheel is not vertically aligned with the bottom wheel: Use the blade tracking knob to tilt the top wheel.
Top wheel is not laterally aligned with the bottom wheel: Adjust the rear adjustment set screws to tilt the top wheel left/right.

Figure 69. Wheel alignment illustration.

Shimming a Wheel

A wheel that is parallel with the other wheel, but is not coplanar, must be shimmed by the distance that it is not in the same plane with the other wheel.

Tip: *Electrical washers work well for shimming the wheel because the can easily be stacked to get the desired height.*

To shim a wheel:

1. DISCONNECT BANDSAW FROM POWER!

2. Adjust the upper wheel tracking so that it is parallel with the bottom wheel.

3. With the straightedge touching both rims of the wheel that does not need to be adjusted, measure the distance away from the other wheel with a fine ruler, as shown in **Figure 70**. The distance measured with the ruler is the distance this wheel must be shimmed.

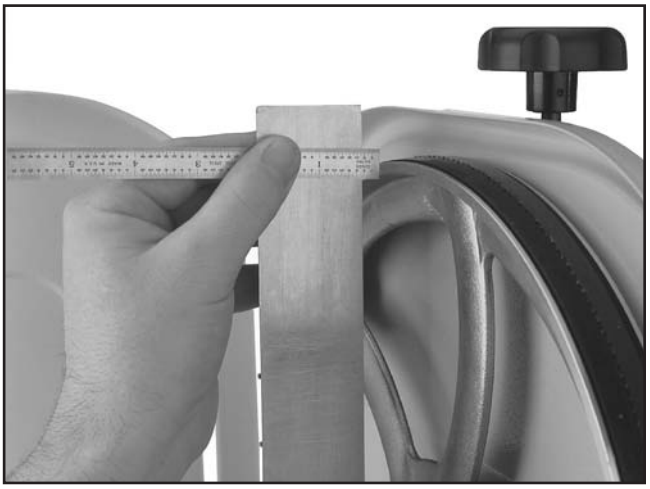


Figure 70. Measuring the distance to shim the wheel to be coplanar.

4. Remove the blade.

5. Remove the wheel to be shimmed. Place as many shims as necessary to correct the gap measured in **Step 3** onto the wheel shaft.

6. Re-install the wheel and secure it in place.

7. Re-install the blade and properly tension it.

8. Perform the previous **Checking Wheel Alignment** procedure. If necessary to make the wheels parallel, repeat this procedure.

9. Close the wheel covers.

10. The first time you get the wheels coplanar, place a mark on each wheel where you held the straightedge, then use this position again in the future if you need to repeat the procedure. This assures repeated accuracy every time you adjust the wheels.

Upper Wheel Lateral Adjustment

If the upper wheel is tilted laterally (side to side), perform the following procedure to make it coplanar with the lower wheel.

There are two set screws in the upper wheel bracket, shown in **Figure 71**, that adjust the wheel tilt from side to side.

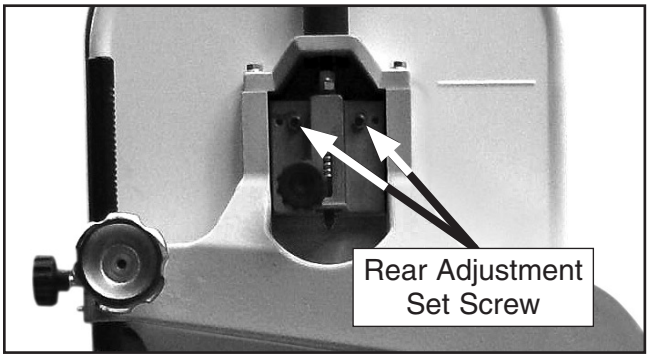


Figure 71. Rear lateral adjustment set screw.

Tools Needed	Qty
Hex Wrench 3mm	1
Wrench or Socket 10mm	1

To adjust the upper wheel laterally:

1. DISCONNECT BANDSAW FROM POWER!

2. Remove the fence and table from the machine.

3. Using a white crayon or other light color marker, mark the upper and lower wheels to indicate the measuring locations, as illustrated in **Figure 72**.

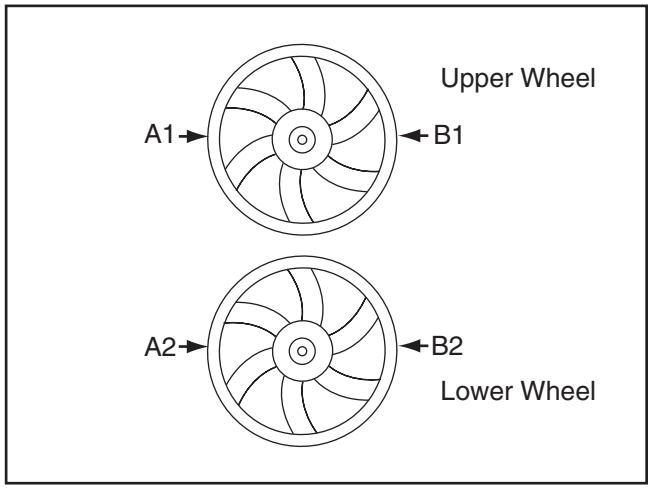


Figure 72. Example of marking upper and lower wheels for consistent measurements.

Note: *Marking the wheels ensures more accurate results in case there are irregularities in the wheels.*

4. Using a straightedge, check the wheels at the A and B locations (see **Figure 72**).

5. Using the 10mm wrench, loosen the hex nuts on the rear adjustment set screws.

6. Using the 3mm hex wrench, adjust the set screws until the upper wheel is coplanar with the lower wheel, see **Figure 73**.

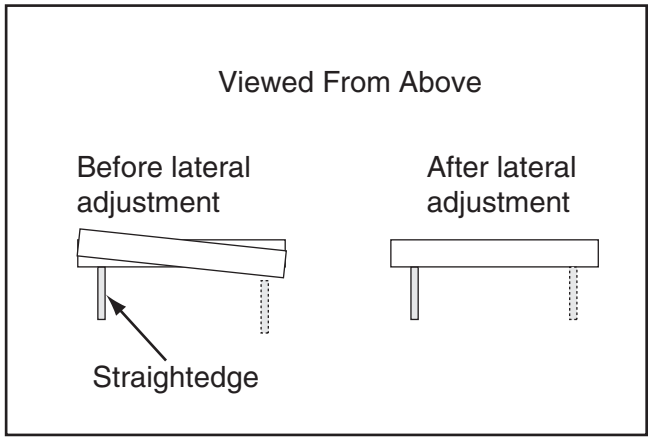


Figure 73. Before and after lateral wheel alignment (viewed from above).

7. Re-tighten the hex nuts loosened in **Step 6**.

Blade Lead

Bandsaw blades may wander off the cut line when sawing, as shown in **Figure 74**. This is called blade lead.

Blade lead is usually caused by too fast of a feed rate, a dull or abused blade, or improper blade tension. If your blade is sharp/undamaged, properly tensioned, and you still have blade lead, perform the following procedures.

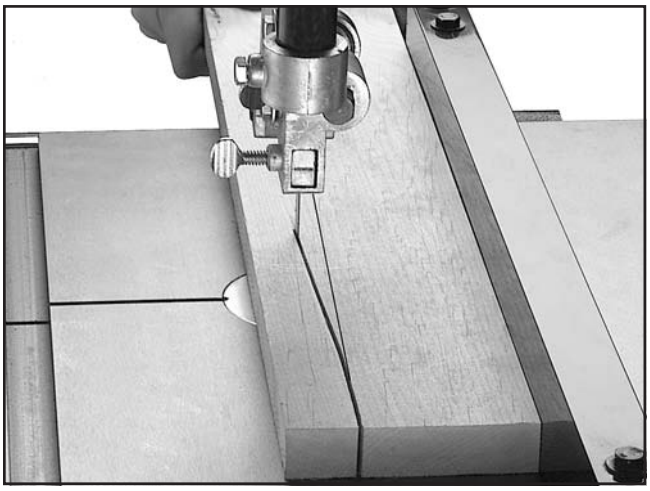


Figure 74. Example of blade lead.

To correct blade lead:

1. Make sure the blade is properly tensioned and the blade guides are adjusted correctly.

2. Use less pressure when feeding the workpiece through the cut.

3. Make sure the miter slot and fence are parallel to the blade line (see the **Aligning Table** and **Aligning Fence** procedures in this manual for detailed information).

4. Perform a test cut with the bandsaw.

   —If there is still blade lead present, compensate for this condition by skewing the fence or shifting the table, as instructed in the following procedures.

To skew your fence:

1. Cut a piece of scrap wood approximately ¾" thick x 3" wide x 17" long. On the wide face of the board, draw a straight line parallel to the long edge.

2. Slide the bandsaw fence out of the way and cut along the line halfway through the board. Turn the bandsaw ***OFF*** and wait for the blade to stop. Do not move the board.

3. Clamp the board to the bandsaw table, then slide the fence over to the board so it barely touches one end of the board.

4. Use a 4mm hex wrench to loosen the four fence adjustment cap screws on top of the fence, skew the fence so that it is parallel with the scrap piece, then re-tighten the cap screws.

5. Make a few cuts using the fence.

   —If blade lead is still present, repeat **Steps 1–4** until the blade and fence are parallel with each other.

   —Or, shift the table, as instructed in the following procedure.

To shift the table:

1. On a scrap piece of wood, mark a line that is perpendicular to the front edge.

2. Cut halfway through the board on the line by pushing it into the blade.

3. Turn the bandsaw ***OFF*** and wait for the blade to stop.

4. Disconnect the bandsaw from power, then use a 10mm wrench to loosen the six hex bolts underneath the table that secure it to the trunnion brackets.

5. Shift the table to compensate for the blade lead, re-tighten the hex bolts, then re-connect the bandsaw to power.

6. Repeat **Steps 1–5** until there is no longer any blade lead.

Fence Scale Calibration

You may need to recalibrate the fence scale after changing or adjusting the blade, or if the scale is not producing accurate cuts. Recalibrate the fence scale by adjusting the hairline indicator on the fence and testing your adjustment by cutting a piece of scrap wood.

Tools Needed	**Qty**
Phillips Screwdriver #1	1

To calibrate the scale:

1. Set the fence anywhere along the scale and locate a piece of scrap wood with at least one straight edge.

   Note: *Joint the edge with a jointer if needed to make the edge straight.*

2. Hold the straight edge of the workpiece firmly against the fence, and feed the workpiece through the saw blade with a push stick.

3. Measure the width of the cut workpiece. The width of the workpiece should match the reading on the fence scale.

4. If the reading on the scale is not the same as the width of the cut workpiece, loosen the two screws on the magnifying window (see **Figure 75**) and adjust it to match the width of the cut workpiece.

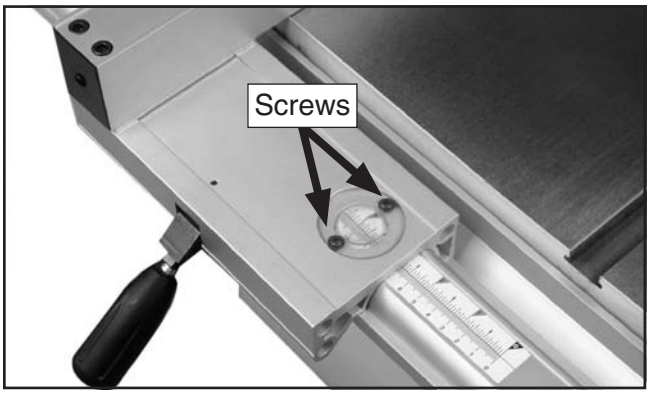


Figure 75. Fence scale window and screws.

5. Re-tighten the screws—the scale is now correctly calibrated.

Blade Tensioner

The blade tensioner may need to be reset for one of the following reasons:

- The blade tension quick release lever will not move to the right position when the tension scale is correctly adjusted for the installed blade.
- You have installed a blade of a different length and the tensioner needs tightened.

The procedure below describes how to decompress the spring in the blade tensioner to allow the quick release lever to perform its intended purpose. If the tensioner needs tightened, reverse the procedure to get the desired results.

Tool Needed	**Qty**
Wrench 14mm	2

To reset the blade tensioner:

1. DISCONNECT BANDSAW FROM POWER!
2. Move the blade tension quick release lever to the left position to release blade tension. **Figure 76**.

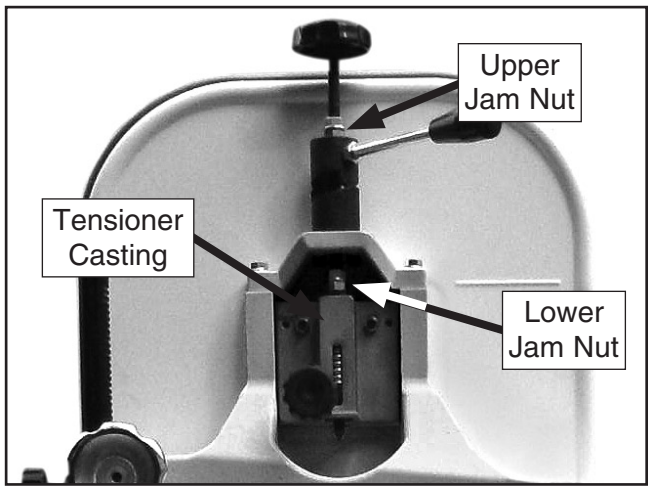


Figure 76. Locations of spacers and tensioner crossbar.

3. Using two 14mm wrenches, loosen the lower jam nuts and thread them up the shaft.
4. Using the two 14mm wrenches, loosen the upper jam nuts and thread them up the shaft the same distance as the lower jam nuts.
5. Test the blade tensioner setting by moving the quick release lever to the right.
6. Use the blade tensioner knob to final tension the blade.
7. Repeat the procedure until the proper tension and release are achieve with the quick release lever.

Note: *Over compressing the spring will wear it out prematurely, making the blade tensioner sloppy and inaccurate. Only compress the spring as needed to remove play in the system.*

SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Compare the manufacture date of your machine to the one stated in this manual, and study this section carefully.

If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine. An updated wiring diagram may be available. **Note:** *Please gather the serial number and manufacture date of your machine before calling. This information can be found on the main machine label.*

⚠WARNING
Wiring Safety Instructions

SHOCK HAZARD. Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

MODIFICATIONS. Modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire. This includes the installation of unapproved aftermarket parts.

WIRE CONNECTIONS. All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

CIRCUIT REQUIREMENTS. You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

WIRE/COMPONENT DAMAGE. Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

MOTOR WIRING. The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.

CAPACITORS/INVERTERS. Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

EXPERIENCING DIFFICULTIES. If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

NOTICE

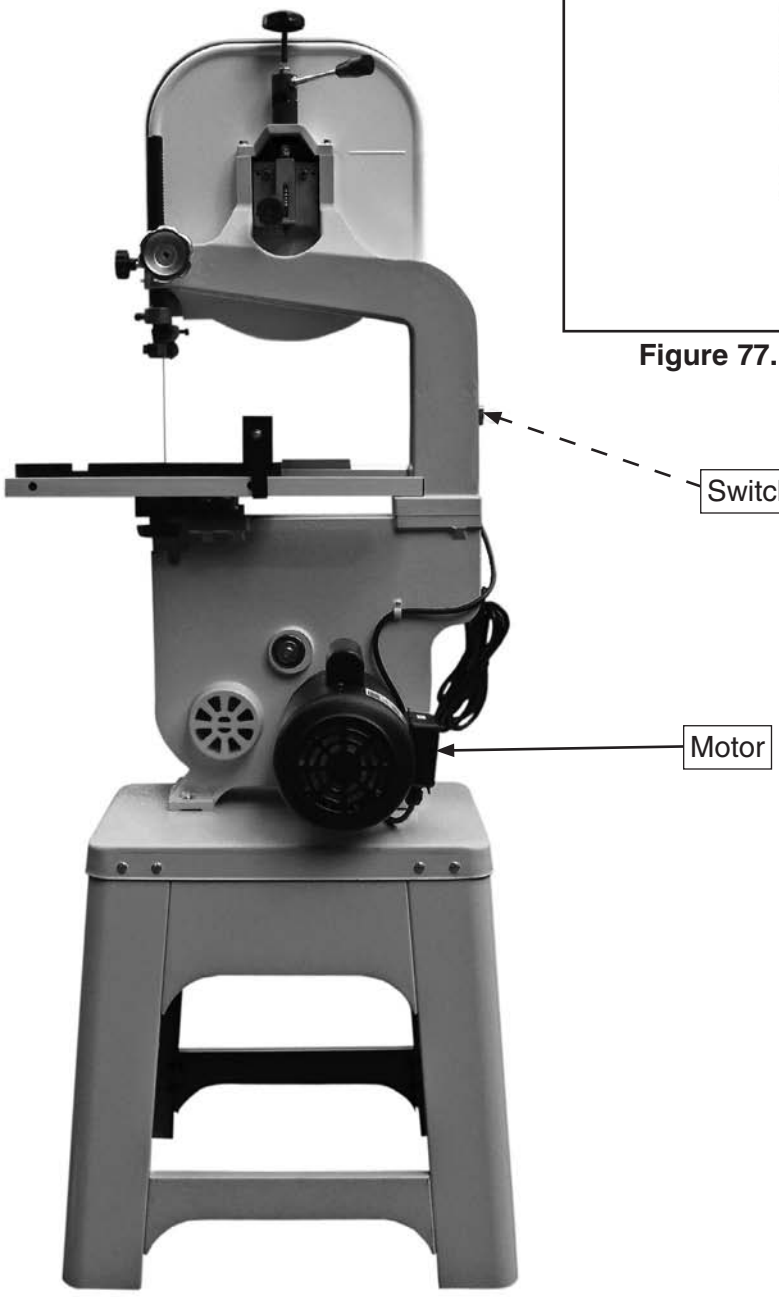
The photos and diagrams included in this section are best viewed in color. You can view these pages in color at www.grizzly.com.

COLOR KEY

BLACK	Bk	BLUE	Bl	YELLOW	Yl	LIGHT BLUE	Lb
WHITE	Wt	BROWN	Br	YELLOW GREEN	Yg	BLUE WHITE	Bw
GREEN	Gn	GRAY	Gy	PURPLE	Pu		
RED	Rd	ORANGE	Or	PINK	Pk	TURQUOISE	Tu

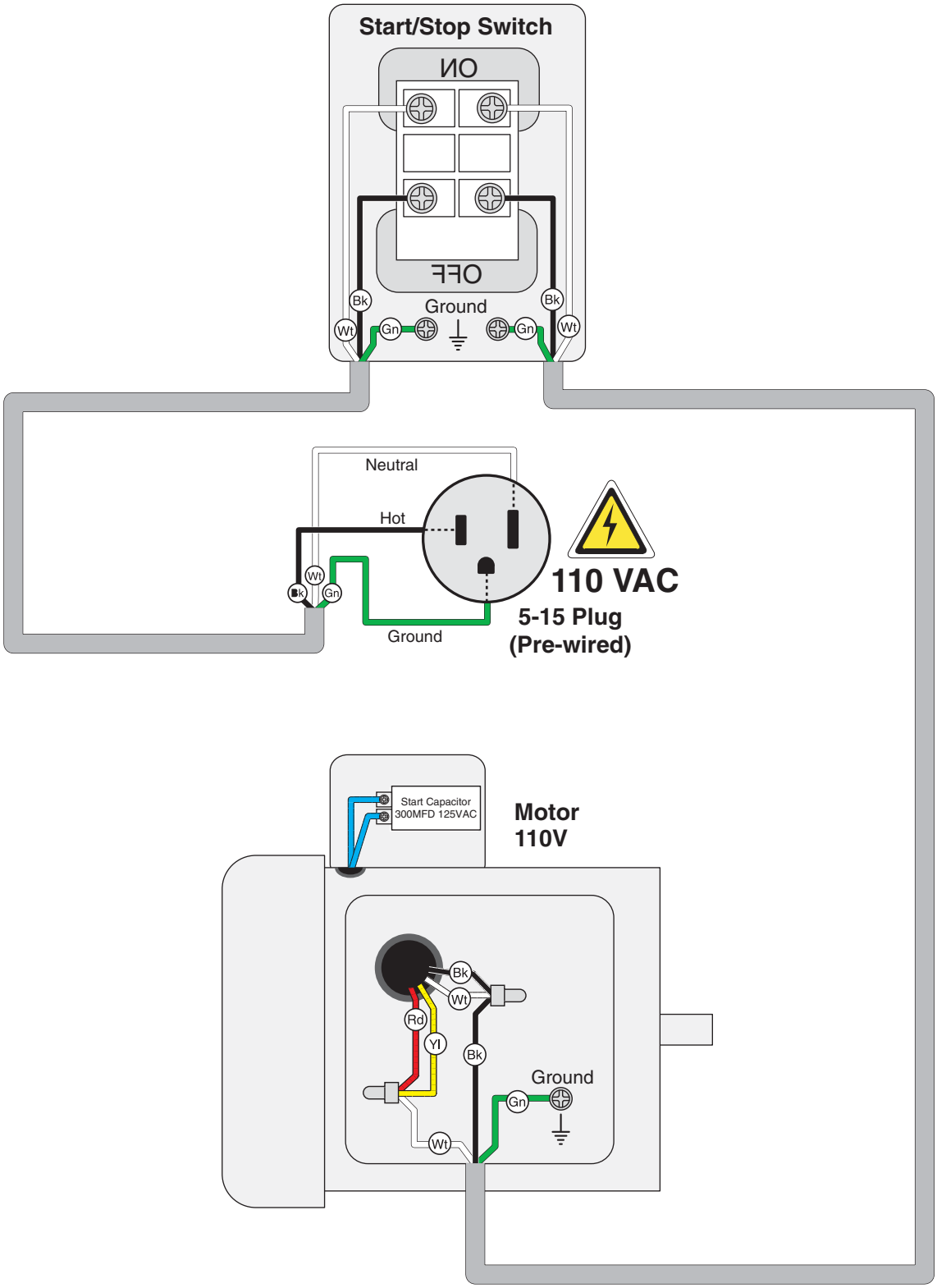
Electrical Locations

Figure 77. G0555LX ON/OFF switch.

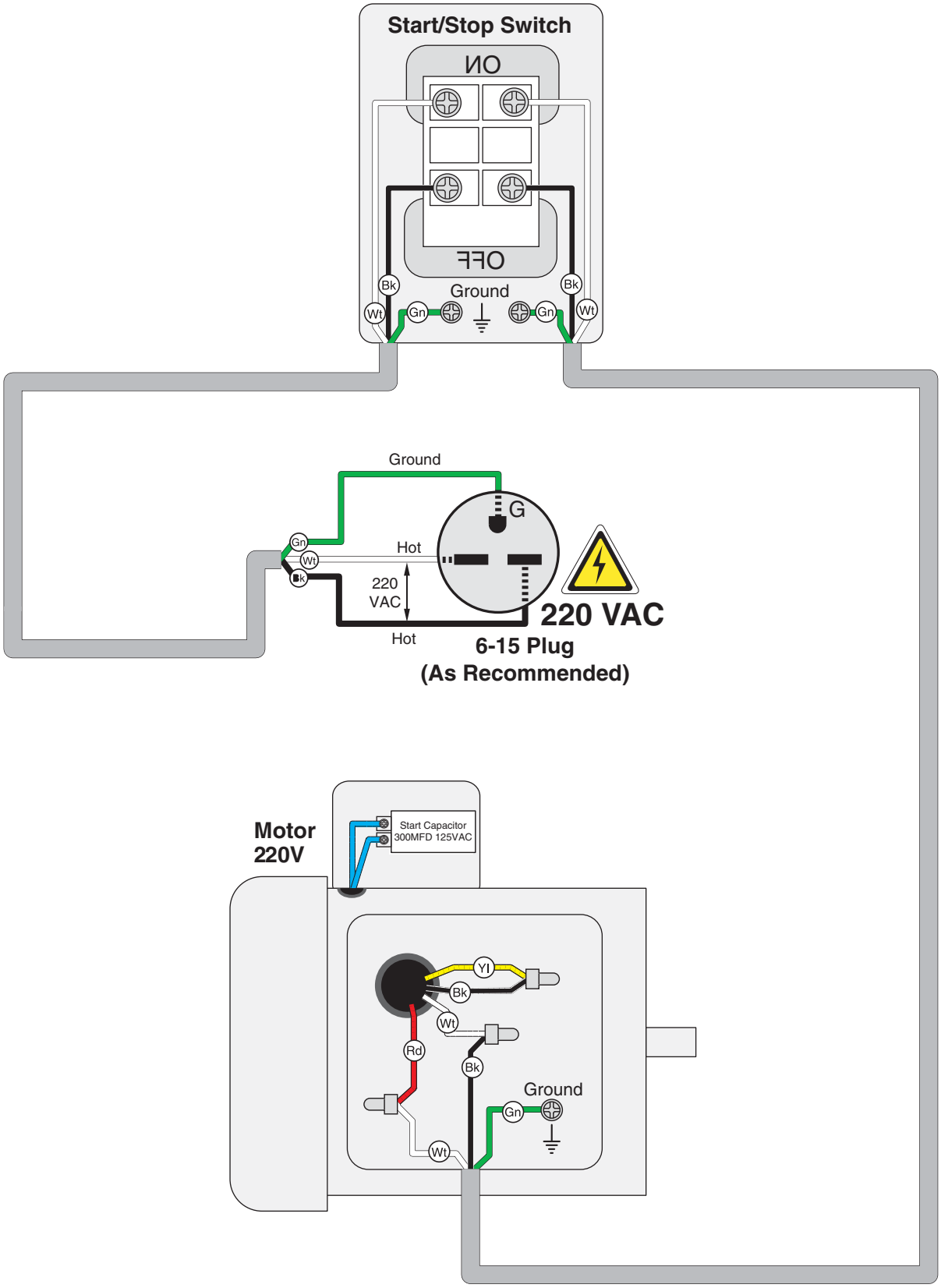


STOP *READ ELECTRICAL SAFETY ON PAGE 53!*

110V (Prewired) Wiring Diagram

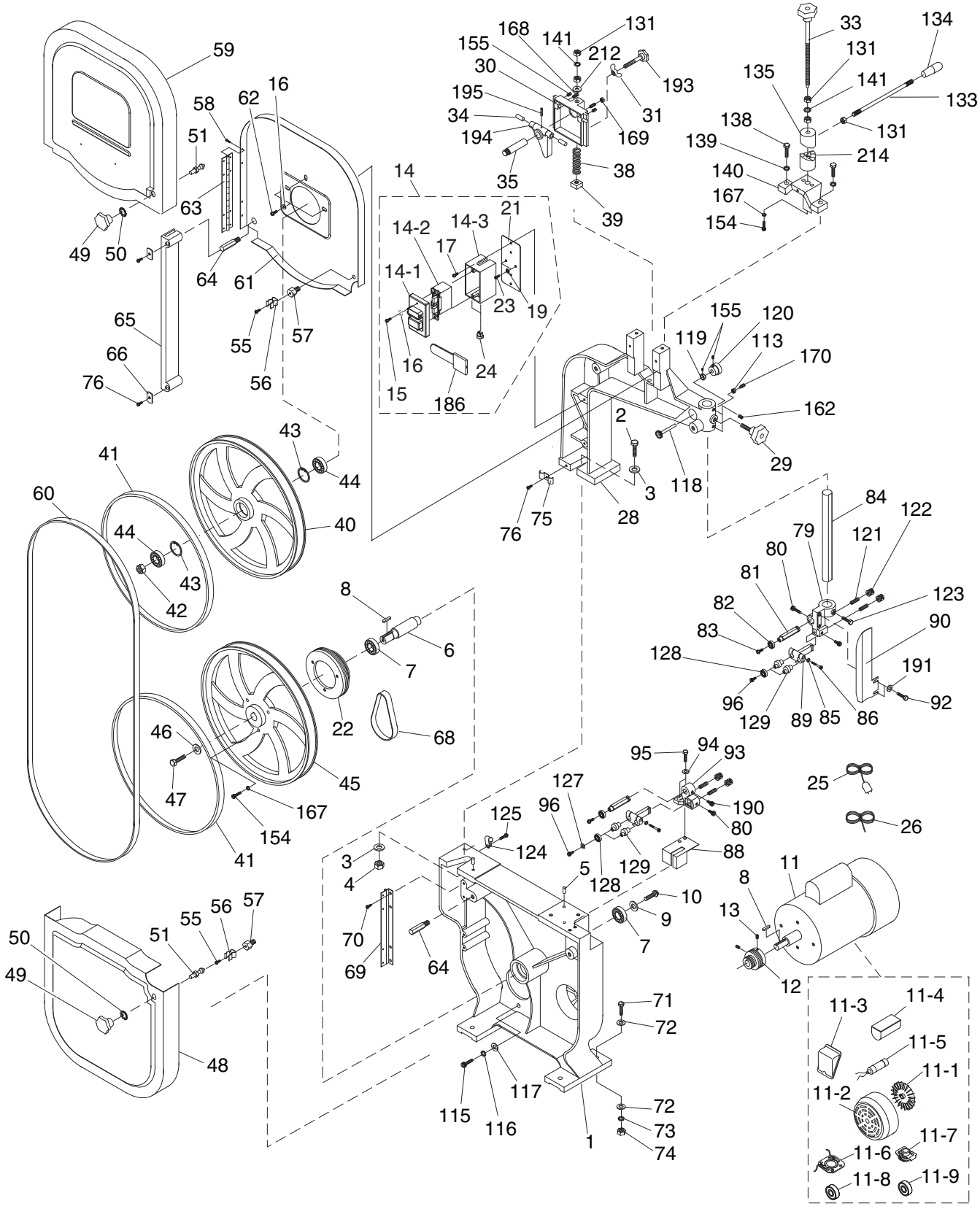


220V (Rewired) Wiring Diagram



SECTION 9: PARTS

Main



Main Parts List

REF	PART #	DESCRIPTION
1	P0555LX001	BASE
2	PB64	HEX BOLT 5/8-11 X 2-1/2
3	PW14	FLAT WASHER 5/8
4	PN04	HEX NUT 5/8-11
5	P0555LX005	GUIDE PIN 6 X 15MM
6	P0555LX006	LOWER WHEEL SHAFT
7	P6204-2RS	BALL BEARING 6204-2RS
8	PK23M	KEY 5 X 5 X 25MM
9	PW07	FLAT WASHER 5/16
10	PB32	HEX BOLT 5/16-18 X 5/8
11	P0555LX011	MOTOR 1HP 110V/220V 1PH
11-1	P0555LX011-1	MOTOR FAN
11-2	P0555LX011-2	FAN COVER
11-3	P0555LX011-3	WIRING BOX
11-4	P0555LX011-4	CAPACITOR COVER
11-5	P0555LX011-5	S CAPACITOR 300M 125V
11-6	P0555LX011-6	CONTACTOR PLATE
11-7	P0555LX011-7	CENTRIFUGAL SWITCH 1725 RPM
11-8	P6205-2RS	BALL BEARING 6205-2RS
11-9	P6204-2RS	BALL BEARING 6204-2RS
12	P0555LX012	MOTOR PULLEY
13	PSS07	SET SCREW 1/4-20 X 1/2
14	P0555LX014	PUSH BUTTON SWITCH ASSY
14-1	P0555LX014-1	SWITCH COVER
14-2	P0555LX014-2	SWITCH CONTROL
14-3	P0555LX014-3	SWITCH BOX
15	P0555LX015	TAP SCREW #10 X 1
16	PW03	FLAT WASHER #10
17	PS22	PHLP HD SCR 10-24 X 5/8
19	PTLW08M	EXT TOOTH WASHER 10MM
21	P0555LX021	SWITCH PLATE
22	P0555LX022	WHEEL PULLEY
23	PS18	PHLP HD SCR 10-24 X 1/4
24	P0555LX024	STRAIN RELIEF
25	P0555LX025	POWER CORD 16G 3W 5-15 120"
26	P0555LX026	MOTOR CORD 16G 3W
28	P0555LX028	UPPER FRAME ARM
29	P0555LX029	KNOB BOLT 5/16-18 X 3/4
30	P0555LX030	SLIDING HOUSING
31	PWN03	WING NUT 5/16-18
33	P0555LX033	TENSION BOLT 3/8-16 X 11-5/8
34	P0555LX034	PIVOT PIN
35	P0555LX035	UPPER WHEEL SHAFT
38	P0555LX038	COMPRESSION SPRING
39	P0555LX039	INDICATOR NUT 3/8 X 16
40	P0555LX040	UPPER WHEEL
41	P0555LX041	WHEEL TIRE

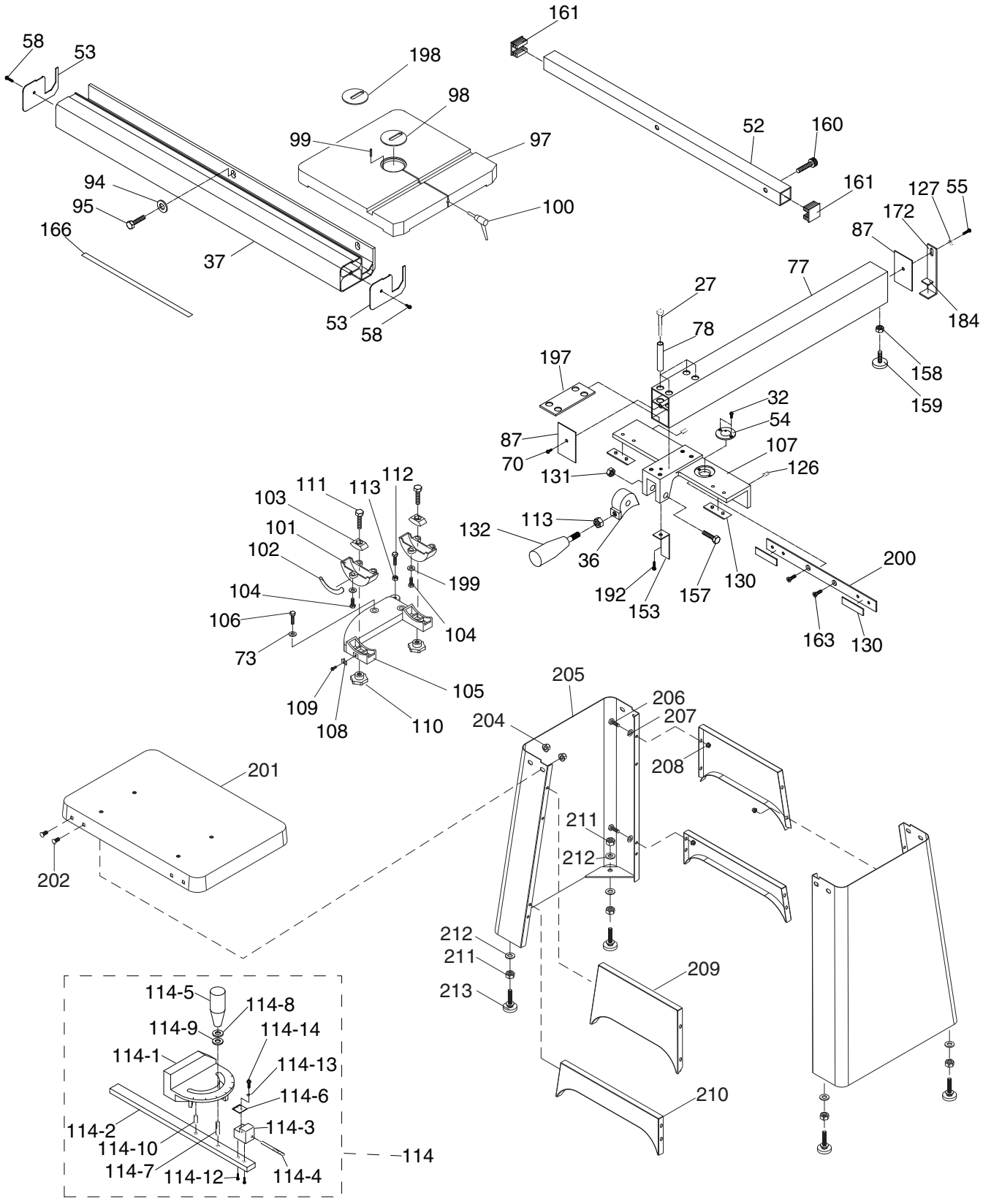
REF	PART #	DESCRIPTION
42	PN01	HEX NUT 1/2-20
43	PR21M	INT RETAINING RING 35MM
44	P6202-2RS	BALL BEARING 6202-2RS
45	P0555LX045	LOWER WHEEL
46	PW07	FLAT WASHER 5/16
47	PB104	HEX BOLT 5/16-18 X 3/4 LH
48	P0555LX048	LOWER WHEEL GUARD
49	P0555LX049	KNOB 5/16-18
50	PTLW03M	INT TOOTH WASHER 8MM
51	P0555LX051	STUD LATCH
55	PS01	PHLP HD SCR 10-24 X 1/2
56	P0555LX056	CATCH
57	P0555LX057	LOCATING BOLT
58	PHTEK7	TAP SCREW #8 X 3/8
59	P0555LX059	FRONT UPPER COVER
60	P0555LX060	SAW BLADE 93-1/2 X 3/8 X 6TPI HOOK
61	P0555LX061	BACK UPPER COVER
62	PFS03	FLANGE SCREW 10-24 X 3/8
63	P0555LX063	UPPER HINGE
64	P0555LX064	STANDOFF STUD-MF
65	P0555LX065	SAW BLADE GUARD
66	P0555LX066	BLADE GUARD WASHER #10
68	P0555LX068	RIBBED V-BELT 200J5
69	P0555LX069	LOWER WHEEL COVER HINGE
70	PS06	PHLP HD SCR 10-24 X 3/8
71	PB11	HEX BOLT 5/16-18 X 1-1/2
72	PW07	FLAT WASHER 5/16
73	PLW01	LOCK WASHER 5/16
74	PN02	HEX NUT 5/16-18
75	P0555LX075	CORD CLAMP
76	PS01	PHLP HD SCR 10-24 X 1/2
79	P0555LX079	UPPER BLADE GUIDE CASTING
80	PCAP04	CAP SCREW 1/4-20 x 1/2
81	P0555LX081	BEARING ARBOR
82	P6000-2RS	BALL BEARING 6000-2RS
83	PFH09	FLAT HD SCR 1/4-20 X 5/16
84	P0555LX084	GUIDE POST
85	PLW03	LOCK WASHER 3/16
86	PCAP110	CAP SCREW 10-24 X 1-3/4
88	P0555LX088	LOWER BLADE GUIDE BRACKET
89	P0555LX089	GUIDE SHAFT BRACKET
90	P0555LX090	UPPER BLADE GUARD
92	PS06	PHLP HD SCR 10-24 X 3/8
93	P0555LX093	LOWER BRACKET POST
94	PW06	FLAT WASHER 1/4
95	PB05	HEX BOLT 1/4-20 X 3/4
96	PCAP109	CAP SCREW 10-32 X 1/4

Main Parts List (continued)

REF	PART #	DESCRIPTION
113	PN02	HEX NUT 5/16-18
115	PB03	HEX BOLT 5/16-18 X 1
116	PLW01	LOCK WASHER 5/16
117	PW07	FLAT WASHER 5/16
118	P0555LX118	PINION SHAFT
119	P0555LX119	LOCK COLLAR
120	P0555LX120	GUIDE POST CONTROL KNOB
121	PSS100	SET SCREW 5/16-24 X 1-1/2
122	P0555LX122	ADJUST NUT
123	PCAP01	CAP SCREW 1/4-20 X 5/8
124	P0555LX124	CORD CLAMP 3/8
125	PS01	PHLP HD SCR 10-24 X 1/2
127	PW04M	FLAT WASHER 10MM
128	P608-2RS	BALL BEARING 608-2RS
129	P0555LX129	ECCENTRIC
131	PN08	HEX NUT 3/8-16
133	P0555LX133	STUD-UDE
134	P0555LX134	PLASTIC HANDLE 3/8-16
135	P0555LX135	UPPER CLUTCH

REF	PART #	DESCRIPTION
138	PB12	HEX BOLT 5/16-18 X 1-1/4
139	PLW01	LOCK WASHER 5/16
140	P0555LX140	CLUTCH SUPPORT BRACKET
141	PLW04	LOCK WASHER 3/8
154	PCAP06	CAP SCREW 1/4-20 X 1
155	PSS04	SET SCREW 1/4-20 X 5/16
162	P0555LX162	BALL PLUNGER 1/4-20 X 1/2
167	PLW02	LOCK WASHER 1/4
168	PSS12	SET SCREW 1/4-20 X 1
169	PN05	HEX NUT 1/4-20
170	P0555LX170	DOG PT SET SCR 5/16-18 X 1/2
186	P0555LX186	SWITCH PADLOCK
190	PCAP17	CAP SCREW 1/4-20 X 3/8
191	PW02M	FLAT WASHER 5MM
193	P0555LX193	KNOB BOLT 5/16-18 X 2
194	P0555LX194	SHAFT BRACKET
195	PRP73M	ROLL PIN 4 X 30
212	PW02	FLAT WASHER 3/8
214	P0555LX214	LOWER CLUTCH

Table, Fence, & Stand

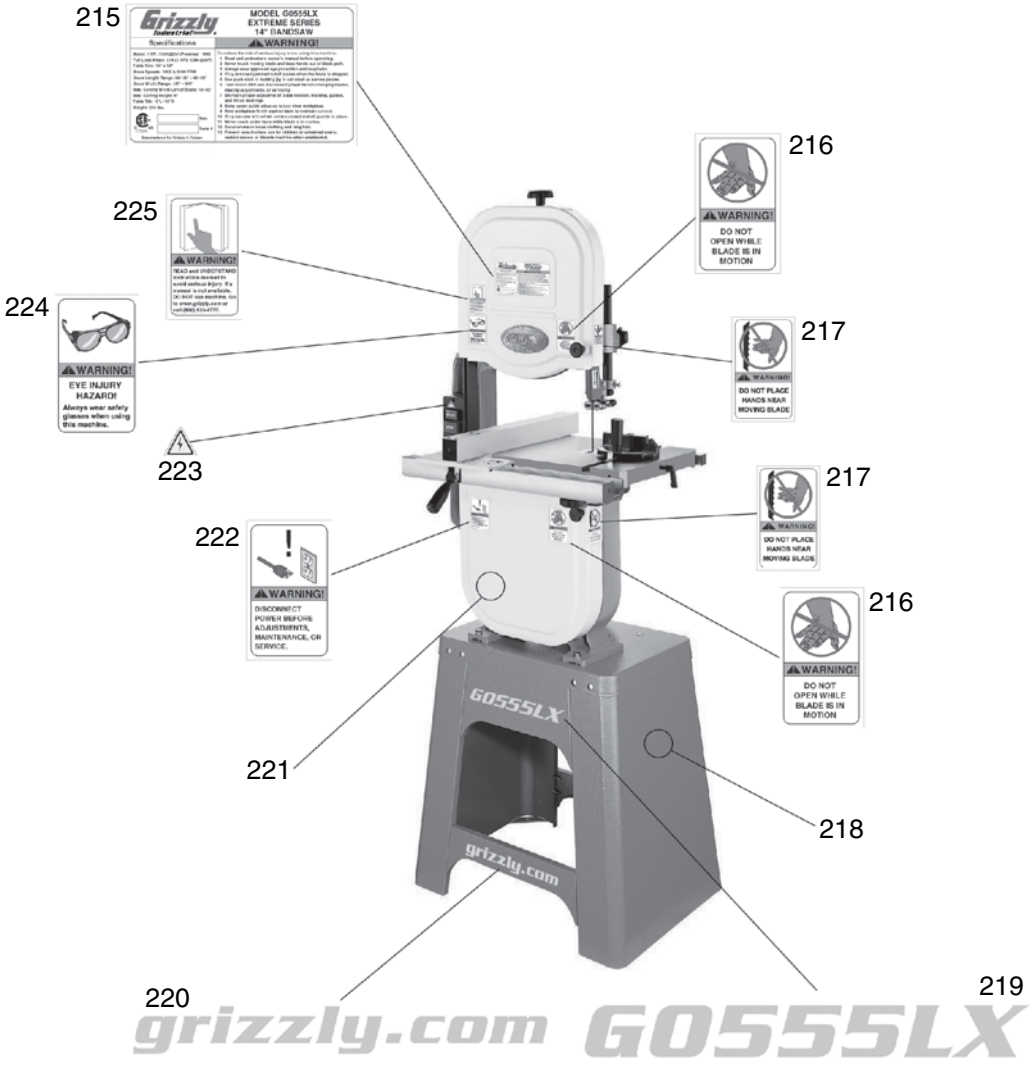


Table, Fence & Guides Parts List

REF	PART #	DESCRIPTION
27	PCAP43	CAP SCREW 1/4-20 X 2-1/2
32	PS28M	PHLP HD SCR M8-1.25 X 30
36	P0555LX036	LOCK CAM
37	P0555LX037	LARGE FENCE RAIL
52	P0555LX052	SMALL FENCE RAIL
53	P0555LX053	LARGE RAIL CAP
54	P0555LX054	MAGNIFIED LENS
55	PS01	PHLP HD SCR 10-24 X 1/2
58	PHTEK7	TAP SCREW #8 X 3/8
70	PS06	PHLP HD SCR 10-24 X 3/8
73	PLW01	LOCK WASHER 5/16
77	P0555LX077	FENCE
78	P0555LX078	SPACER
87	P0555LX087	FENCE CAP
94	PW06	FLAT WASHER 1/4
95	PB05	HEX BOLT 1/4-20 X 3/4
97	P0555LX097	TABLE
98	P0555LX098	LARGE TABLE INSERT
99	PRP15M	ROLL PIN 3 X 8
100	P0555LX100	TABLE LOCK PIN
101	P0555LX101	TRUNNION
102	P0555LX102	TILT SCALE
103	P0555LX103	TRUNNION CLAMP SHOE
104	PB19	HEX BOLT 1/4-20 X 1/2
105	P0555LX105	TRUNNION BASE
106	PB12	HEX BOLT 5/16-18 X 1-1/4
107	P0555LX107	FENCE CARRIAGE, ALUMINUM
108	P0555LX108	POINTER
109	PS18	PHLP HD SCR 10-24 X 1/4
110	P0555LX110	FEMALE KNOB 3/8-16
111	PB58	HEX BOLT 3/8-16 X 2
112	PB22	HEX BOLT 5/16-18 X 1-3/4
113	PN02	HEX NUT 5/16-18
114	P0555LX114	MITER GAUGE ASSY
114-1	P0555LX114-1	MITER GAUGE BODY
114-2	P0555LX114-2	MITER BAR
114-3	P0555LX114-3	STOP BLOCK
114-4	P0555LX114-4	STOP DOWEL
114-5	P0555LX114-5	FEMALE HANDLE 1/4-20
114-6	P0555LX114-6	SCALE PLATE

REF	PART #	DESCRIPTION
114-7	P0555LX114-7	STUD-SE 1/4-20 X 1-1/8
114-8	P0555LX114-8	PLASTIC FLAT WASHER 1/4
114-9	PW06	FLAT WASHER 1/4
114-10	P0555LX114-10	STUD-SE 1/4-20 X 3/4
114-12	PFH08	FLAT HD SCR 10-24 X 1/2
114-13	PW02M	FLAT WASHER 5MM
114-14	PS01	PHLP HD SCR 10-24 X 1/2
126	PSS02	SET SCREW 5/16-18 X 3/8
127	PW04M	FLAT WASHER 10MM
130	P0555LX130	BEARING PAD
131	PN08	HEX NUT 3/8-16
132	P0555LX132	HANDLE BOLT 5/16-18
153	P0555LX153	CAM WEAR PLATE
157	PB58	HEX BOLT 3/8-16 X 2
158	PN01M	HEX NUT M6-1
159	P0555LX159	RUB FOOT M6-1.0
160	PCAP01	CAP SCREW 1/4-20 X 5/8
161	P0555LX161	REAR RAIL END CAP
163	PFH19	FLAT HD SCR 1/4-20 X 3/8
166	P0555LX166	FENCE SCALE
169	PN05	HEX NUT 1/4-20
172	P0555LX172	L BRACE
184	P0555LX184	SMALL FENCE PAD
192	PFS03	FLANGE SCREW 10-24 X 3/8
197	P0555LX197	PLATE
198	P0555LX198	SMALL TABLE INSERT
199	PW06	FLAT WASHER 1/4
200	P0555LX200	ADJUST PLATE
201	P0555LX201	STAND TOP
202	PCB01	CARRIAGE BOLT 5/16-18 X 5/8
204	PFN02	FLANGE NUT 5/16-18
205	P0555LX205	STAND SIDE
206	PB02	HEX BOLT 1/4-20 X 5/8
207	PW06	FLAT WASHER 1/4
208	PFN01	FLANGE NUT 1/4-20
209	P0555LX209	UPPER STAND BRACE
210	P0555LX210	LOWER STAND BRACE
211	PN08	HEX NUT 3/8-16
212	PW02	FLAT WASHER 3/8
213	P0555LX213	STAND FOOT 3/8-16 X 2

Labels



REF	PART #	DESCRIPTION
215	P0555LX215	MACHINE ID LABEL CSA
216	PLABEL-23	BLADE DOOR LABEL
217	PLABEL-19B	BANDSAW BLADE LABEL
218	PPAINT-1	TOUCH UP PAINT-GRIZZLY GREEN
219	P0555LX219	MODEL NUMBER LABEL
220	P0555LX220	GRIZZLY.COM LABEL

REF	PART #	DESCRIPTION
221	PPAINT-11	TOUCH UP PAINT-PUTTY
222	PLABEL-62A	DISCONNECT POWER LABEL
223	PLABEL-14A	ELECTRICITY LABEL
224	PLABEL-11A	SAFETY GLASSES LABEL
225	PLABEL-12A	READ MANUAL LABEL

⚠WARNING

Safety labels help reduce the risk of serious injury caused by machine hazards. If any label comes off or becomes unreadable, the owner of this machine MUST replace it in the original location before resuming operations. For replacements, contact (800) 523-4777 or www.grizzly.com.

Grizzly Industrial, Inc. WARRANTY CARD

Name _____

Street _____

City _____ State _____ Zip _____

Phone # _____ Email _____

Model # _____ Order # _____ Serial # _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. ***Of course, all information is strictly confidential.***

1. How did you learn about us?

____ Advertisement ____ Friend ____ Catalog
____ Card Deck ____ Website ____ Other:

2. Which of the following magazines do you subscribe to?

____ Cabinetmaker & FDM
____ Family Handyman
____ Hand Loader
____ Handy
____ Home Shop Machinist
____ Journal of Light Cont.
____ Live Steam
____ Model Airplane News
____ Old House Journal
____ Popular Mechanics
____ Popular Science
____ Popular Woodworking
____ Precision Shooter
____ Projects in Metal
____ RC Modeler
____ Rifle
____ Shop Notes
____ Shotgun News
____ Today's Homeowner
____ Wood
____ Wooden Boat
____ Woodshop News
____ Woodsmith
____ Woodwork
____ Woodworker West
____ Woodworker's Journal
____ Other:

3. What is your annual household income?

____ $20,000-$29,000 ____ $30,000-$39,000 ____ $40,000-$49,000
____ $50,000-$59,000 ____ $60,000-$69,000 ____ $70,000+

4. What is your age group?

____ 20-29 ____ 30-39 ____ 40-49
____ 50-59 ____ 60-69 ____ 70+

5. How long have you been a woodworker/metalworker?

____ 0-2 Years ____ 2-8 Years ____ 8-20 Years ____ 20+ Years

6. How many of your machines or tools are Grizzly?

____ 0-2 ____ 3-5 ____ 6-9 ____ 10+

7. Do you think your machine represents a good value? _____Yes _____No

8. Would you recommend Grizzly Industrial to a friend? _____Yes _____No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?
Note: *We never use names more than 3 times.* _____Yes _____No

10. Comments: _____

_____

_____

CUT ALONG DOTTED LINE

FOLD ALONG DOTTED LINE

Place
Stamp
Here

GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069

FOLD ALONG DOTTED LINE

Send a Grizzly Catalog to a friend:

Name_____

Street_____

City_____State_____Zip_____

TAPE ALONG EDGES--PLEASE DO NOT STAPLE

WARRANTY AND RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number,'' which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

grizzly.com®

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